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(54) **PROCESS AND APPARATUS FOR FORMING A RESIN MOULDED PRODUCT INCLUDING A MOULDED BODY AND A MOULDED COATING**

VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG EINES KUNSTSTOFFGEGENSTANDES
BESTEHEND AUS EINEM GEGOSSENEN KÖRPER UND EINER GEGOSSENEN
BESCHICHTUNG

PROCEDE ET DISPOSITIF DE FABRICATION DE PRODUITS MOULES EN RESINE
COMPRENANT UN CORPS MOULE ET UNE COUCHE MOULEE

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Description

Technical Background of the Invention

- 5 [0001] This invention relates to a process and an apparatus for forming a resin molded product including a molded body and a molded coating according to the precharacterising part of claim 1 and claim 9 respectively. A process and an apparatus of this type is known from e.g. JP-A-03-203 614.

Disclosure of Prior Art

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[0002] In molding the bathtub, paneling or the like made of a thermosetting resin, it has been common to form a resin coating on one side surface of the same, on the inner side surface in the case of the bathtub, for example, and as a practical process there has been a process known as an in-mold coating process, for example. According to this process, a pair of split molds comprising a stationary mold and a movable mold (generally constituted by such male mold as a lower mold and such female mold as an upper mold) are employed, and the process comprises a step of obtaining resin moldings of a predetermined shape with such molding material as a bulk or sheet shaped resin molding material (BMC, SMC etc) disposed between the split molds and thereafter subjected to a mold clamping (compression) and a hot pressing, and a step of coating the surface of each molding with the fluid coating material injected between one side surface of the resin molding and a surface of the mold, which process is advantageous in that the molding and coating can be carried out with the same apparatus employed and through sequential steps. In addition to this advantage, it is also possible to obtain a molded resin product having the surface beautifully coated and excellent in the smoothness.

15 [0003] Since in the foregoing process the molded resin product is manufactured generally with a thermosetting resin, the molding requires the heating along with the compression, whereas it is also necessary that, because the thermosetting resin is employed generally as the foregoing coating material, the material maintains the fluidity at its injecting step as cooled to an extent not causing the curing to excessively advance. Accordingly, there is a problem that temperature administration of the mold is complicated. In injecting the fluid coating material, further, it has been general that a mold which allows an excess body part to be formed at part of peripheral edge of the molded resin product is employed, and the fluid coating material is injected through a nozzle facing the excess body part, but there remains a problem that the coating material cannot be distributed constantly stably and sufficiently to the peripheral part at positions separated far from the excessive body part. Further, to cope with this, it may be possible to employ an arrangement having a plurality of the excess body parts, but it becomes necessary to provide mutually independent injecting means with respect to them, and there arises a problem that required costs for the mold rise or maintenance/administration or productivity of the apparatus is deteriorated.

20 [0004] With respect to the above, there has been suggested an improved apparatus such as disclosed in Japanese Patent Laid-Open Publication No. 62-160216, according to which there has been provided an apparatus for supplying the coating material from a substantially central position on reverse side of the resin molding, while the upper mold is arranged to be movable and the lower mold is made to be stationary. In the central part of the lower mold, means for injecting the coating material is provided, which means is provided with a casing incorporating a plug-shaped hole forming means for free projection and retraction, and this casing is disposed with a space interposed for restraining as much as possible a heat intrusion from its circumference, in particular, from the lower mold. When the foregoing resin molding is prepared, the hole forming means is projected to render the injecting means for the coating material to be in a state where its nozzle is closed, and the compression molding of the molding material is performed in a state where a through hole is made in the molding from the reverse side of the molding upon formation of the foregoing hole. Next, the hole forming means is retracted into the interior of the injecting means for the coating material, clamping pressure for the upper mold is released to allow it to be elevated and to have a space formed between a bottom face of the upper mold and the molding, and the fluid coating material is injected into the space by the injecting means for the coating material through the through hole in the resin molding. According to the present apparatus, therefore, the coating material can be injected from the reverse side of the molding, and the coating surface of the molded resin product can be formed uniformly.

45 [0005] In the case where the foregoing apparatus is used, however, there is a risk that the resin coating layer of a uniform thickness cannot be formed on the upper surface of the molding, due to that the molding is caused to adhere to the upper mold so as to move following the upper mold when the same is slightly elevated, and that, upon injection of the fluid coating material, this material intrudes between bottom surface of the mold and upper surface of the lower mold.

50 [0006] Here, there has been suggested a system in which the process of injecting the coating material from the front surface side of the resin molding is employed again, the coating material is injected without elevating the upper mold, that is, in a state where the compression force by the upper mold is slightly lowered, the upper mold is pushed up with injecting pressure of the coating material and the coating with the coating material is performed (which shall be referred

to as "resin coating" hereunder). However, it has been relatively difficult to balance the compression force of the upper mold with the injection pressure for the coating material, and there have been many problems unsolved in respect of deflashing upon formation of the moldings or in the retention of uniformity of the resin coating layer.

[0007] JP-A-03-203614 discloses an in-mould coating moulding for resin coating, wherein a moulding material is compressed with use of splits moulds provided with a part at a position on outer periphery and slidable, a space is defined between one side surface of a moulding and an opposing surface of the moulds by mutually separating them prior to a complete curing, a gas flow is formed within the moulds and towards the outer periphery so as to discharge any foreign material through the space to the exterior of the mould and a fluid material is injected into said space between the moulding and the surface of the mould and the moulds are again clamped during a complete curing.

[0008] US-A-4 647 274 shows an in-mold apparatus for forming a multilayered moulded product.

[0009] JP-A-60-31931 discloses a moulding method to obtain a resin product.

[0010] JP-A-63-128918 discloses a process for reforming thermoplastic resin.

[0011] EP-A-0 039 588 relates to in-mould coating composition and a method for making coated articles.

[0012] US-A-4 207 049 shows a device for mould coating plastic parts.

[0013] JP-A-55-154123 discloses in-mould coating of a "bath body".

[0014] JP-A-50-137250 shows an outer face coating (b) over bottom face and part of tapered side face of a bathtub (a).

Description of the Invention

[0015] Accordingly, the object of the present invention is to solve the foregoing problems, and to provide a process and an apparatus for the resin-coating in a mold which allows the deflashing of the resin moldings to be reliably carried out and the molding to be coated with the coating material in a uniform thickness over the whole surface of the molding. The above object is attained according to the invention by a process as defined in claim 1 and by an apparatus as defined in claim 9.

[0016] Particular embodiments of the invention are the subject of the relevant dependant claims.

[0017] In the process for resin-coating in a mold, a molding material is compression molded with a mold comprising upper and lower molds employed, a space is defined at least between one surface on one mold side of the resin molding and the one mold facing the surface with engagement of the upper and lower molds loosened prior to a complete curing of the moldings, any mixing of foreign substance is prevented by formation of a gas flow path between both molds through the space, then a fluid coating material is injected into the space between the molding and the surface of the one mold, and the molds are clamped again to have them cured under a pressure.

[0018] The resin-coating process is capable of, in an event where the resin moldings have an uneven configuration, eliminating any deficiency in adhesion properties of the resin coating layer with respect to the moldings due to an insufficient compression, and rendering surface quality of the moldings to be excellent. In the resin-coating process in which a space is defined by one mold of stationary type and the other mold of a type movable with respect to the one mold, a resin molding is formed with a mold material compression-molded within this space, thereafter a resin coating material is injected onto a surface of the molding, and a resin coating layer is formed by performing again the compression molding. The process is constituted to compress an outer surface of the molding with a fluid injected from an injecting port provided to the molding after the re-compression molding.

[0019] The resin-coating apparatus can perform in smooth manner a retraction of a plug member from a coating-material injecting member without causing the coating-material injecting member and plug member to engage with either one of split upper and lower molds and without causing tip end portions of these coating-material injecting member and plug member to be crushed, and further can perform the molding in excellent manner without hindrance to the injection of the fluid coating material.

[0020] The resin-coating apparatus for forming a resin coating layer on one side surface of a resin molding molded with split upper and lower molds employed, is constituted by an injecting member for the coating material having therein an injecting hole for the coating material and opened at a tip end, the injecting member being provided in one of the molds, an auxiliary mold provided in the other mold to face the injecting member for the coating material but not to engage with the opened tip end of the injecting hole for the coating material, and a plug member provided within the injecting hole to penetrate therethrough for forward and backward movement.

[0021] Further the resin-coating apparatus can prevent the fluid coating material from intruding to a surface on the side where the resin coating layer to be formed on the molding is not required, and can injecting the fluid coating material exclusively only to a surface which requires the resin coating layer.

[0022] The resin-coating apparatus in which moldings are formed with split molds in one of which a nozzle for injecting a fluid coating material is formed, and a resin coating layer is formed between the opposite side surface and the other surface with the fluid coating material injected from the injecting nozzle and supplied penetratingly through the molding to its opposite side surface, is constituted by a groove or projection provided on a surface of the one mold having the

injecting nozzle to externally enclose the position of this injecting nozzle.

[0023] The resin-coating apparatus does not hinder the nozzle mechanism for injecting the fluid coating material, so as to attain a stable and highly efficient production with an excellent surface quality.

[0024] The resin-coating apparatus forms moldings with the molding material of thermosetting resin pressure-molded between a pair of split, upper and lower molds of stationary and movable types, defines a space between either one of the molds of the stationary or movable type and the molding with the movable type mold moved prior to a complete curing of the molding, and then forms the resin coating layer on one side surface of the resin molding with the fluid coating material injected into the space, pressurized again and cured. The apparatus constituted by an air ejecting air-nozzle mechanism provided for being opened and closed in the mold on the side contacting with the fluid coating material injected, which air-nozzle mechanism comprising a cylinder having a valve seat and movable toward and away from the space and an air valve movable independently forward and backward within the cylinder, so that an air nozzle will be released when the resin molding is to be urged against the other mold with air ejected and will be closed after completion of this urging action.

[0025] The resin-coating apparatus is capable of controlling a leaking amount of the coating material out of shear edge to be proper, so as to be able to check the leakage of the coating material to the exterior of the molds and to shorten required time for cleaning the molds after the molding.

[0026] The resin-coating apparatus for forming the resin coating layer with the fluid coating material injected onto one side surface of the molding molded with the split upper and lower molds is constituted by forming the shear edge at a side edge part of the split mold in two stages of inside shear edge and outside shear edge, and rendering preferably a space between the molds at their outside shear edges to be smaller than that at their inside shear edges.

[0027] The molding material for performing the in-mold coating can comprise a thermosetting resin, a radical polymerization initiator, a filler and a curing retarder and allows an in-mold coated molded product excellent in the adhesion with respect to the coating material to be obtained. As the curing retarder, in this event, a preferable one should be any of molding materials containing SH group of carbon number 5 to 20; one or more molding material selected from the group consisting of α -methylstyrene, stilbene, 4-phenoxy styrene, cumene and 4-methyl-2,4-diphenyl-pentene-1; and monoterpene hydrocarbon.

[0028] The resin molded product, in particular, can be a bathtub, which is capable of attaining a reduction of cost with an amount of use of the coating material reduced as much as possible, improving such horizontal surface part as a flange part, a bottom surface part of main body or the like in the resistance properties, and presenting a profundity in the appearance.

[0029] The bathtub as the resin molded product is constituted by forming the resin coating layer on the surface of the molding having at least a flange part, main-body bottom surface part, extended flange part, corner parts and slope parts between the corner parts, and rendering the thickness of the resin coating layer at such horizontal plane parts as the flange, bottom surface and the like parts to be larger than that of other parts.

[0030] Other advantages of the present invention shall be made clear in the following description with reference to the accompanying drawings.

Brief Explanation of the Drawings

[0031]

FIGURES 1 through 11 are explanatory views respectively for the steps in one embodiment of the resin-coating process according to the present invention;

FIGS. 12 and 13 are respectively sectioned views at a main part of an apparatus employed in a resin-coating process according to the present invention of FIGS. 1 through 11;

FIG. 14 is an explanatory view for a resin-coating apparatus employed in another embodiment of the manufacturing process according to the present invention;

FIGS. 15 through 23 are explanatory views for manufacturing steps of the present invention in the apparatus shown in FIG. 14;

FIG. 24 is a fragmentary sectioned view at the time of clamping the molds in another embodiment of the resin-coating apparatus according to the present invention;

FIG. 25 is a fragmentary sectioned view showing a state in which an auxiliary mold is retracted from a state of FIG. 24 in the apparatus of FIG. 24;

FIGS. 26 through 34 are respectively fragmentary sectioned views as magnified of the apparatus of FIG. 24 showing respectively different operating states;

FIG. 35 is a fragmentary sectioned view of the resin-coating apparatus in another embodiment according to the present invention, at the time when the molds are clamped;

FIG. 36 is a fragmentary sectioned view showing a state in which the fluid resin molding is injected from a state of

FIG. 35;

FIG. 37 is a sectioned view as magnified of a main part in another working aspect of the apparatus of FIG. 35;
FIG. 38 is a sectioned view as magnified of the main part in another working aspect closely resembling the apparatus of FIG. 35;

FIG. 39 is a schematic bottom view of FIGS. 37 and 38;

FIG. 40 is a sectioned view as magnified of the main part in another working aspect and corresponding to FIG. 37;

FIG. 41 is a sectioned view as magnified of the main part in still another working aspect and corresponding to FIG. 38;

FIG. 42 is a sectioned view as magnified of the main part in yet another working aspect and corresponding to FIG. 36;

FIGS. 43 to 46 are explanatory views for the steps from a mold opening to the fluid coating material injection;

FIGS. 47 and 48 are explanatory views for operating sequence respectively of the apparatus in FIGS. 43 to 46;

FIGS. 49 to 51 are sectioned views at different position from FIGS. 47 and 48 for explaining the operating sequence of the apparatus in FIGS. 43 to 46;

FIG. 52 is a fragmentary sectioned view of the resin-coating apparatus in another embodiment according to the present invention;

FIG. 53 is a sectioned view as magnified of a main part of FIG. 52;

FIG. 54 is a fragmentary sectioned view showing a state in which the coating material is injected and re-pressurized from the state of FIG. 52;

FIG. 55 is a sectioned view as magnified of the main part of FIG. 54;

FIG. 56 is a sectioned view as magnified of the main part of the resin-coating apparatus in another embodiment according to the present invention at the time when the coating material is injected and re-pressurized;

FIG. 57 is a sectioned view as magnified of the main part of the resin-coating apparatus in still another embodiment according to the present invention at the time when the coating material is injected and re-pressurized;

FIG. 58 is a sectioned view of a bathtub as the molded product according to the present invention;

FIG. 59 is a plan view of FIG. 58;

FIG. 60 is an explanatory view for the mold including upper and lower molds for manufacturing the bathtub of FIG. 58;

FIGS. 61 to 66 are explanatory views for manufacturing steps of the bathtub of FIG. 58; and

FIG. 67 is a magnified view for explaining the width of the space at a part A encircled in FIG. 63.

Best Mode for Working the Invention

[0032] Referring to FIGS. 1 through 11, there are shown fragmentary sectioned views showing the concept of typical apparatus for working the process of the present invention, and FIGS. 12 and 13 are conceptual diagrams of the step of injecting the fluid coating material. While in the apparatus in the embodiment as shown an upper mold 12 as a second mold is made movable with respect to a lower mold 11 as a first mold and the lower mold 11 is provided substantially in the center with an injecting means 13 for the coating material (which shall be also referred to hereinafter simply as an injecting member 13), it is also possible to modify the design so that, inversely, the upper mold 12 will be stationary with the lower mold 11 made movable, and the upper mold 12 is provided substantially in the center with the injecting member 13.

[0033] Referring also to FIGS. 12 and 13 here, the injecting member 13 is provided with a casing 14 opened at a tip end, and internally with a hole forming means 15 to be movable forward and backward, penetrating through the casing 14. Upon injection of the coating material, the upper mold 12 is raised to lift a molding 10, following the upper mold 12, so that a space S1 will be formed below the molding, that is, between the molding and the lower mold 11. At the same time, the hole forming means 15 is moved backward in lower direction to form a space S2 within the casing 14. As the fluid coating material is injected in this state, the coating material is made to fill between the front side surface, that is, top surface 11a of the lower mold 11 and lower surface 10a of the molding 10, a uniform resin coating layer 10A can be thereby formed on lower side of the molding 10, upon which the arrangement is so made that the resin coating layer 10A can be effectively prevented from expanding to upper side of the molding 10. Further, the injecting member 13 is provided with an injecting pump 16 for the injection of the fluid coating material and with an air pump 17.

[0034] Referring next to the manufacturing process for the resin molding according to the present invention with the foregoing resin-coating apparatus employed, such molding material as BMC, SMC or the like is first supplied with respect to the lower mold 11 in a state where the upper mold 12 is opened as shown in FIG. 1. Next, as shown in FIG. 2, the upper mold 12 is gradually lowered and brought into such mold clamping state as in FIG. 3, and a curing reaction of the molding material is advanced as disposed between the lower and upper molds 11 and 12 heated. At this time, the pressurizing is ceased before a complete curing is reached, and the upper mold 12 is raised slightly with respect to the lower mold 11 as shown in FIG. 4. In order to attain smooth sliding engagement between the lower and upper molds

11 and 12, they are provided with tapers 11b and 12b. Between these tapers 11b and 12b, a space S is formed, the air pump 17 blows a compressed air as shown in FIG. 5 to cause an air stream to occur in the space S between the molding 10 which is half cured and the lower mold 11, and any molding-flash or dust present in the space S are blown off from the upper and lower molds. Thereafter, as shown in FIGS. 6 and 7, the fluid coating material is injected. Provided in this case that the coating material is injected at an enough amount for slightly overflowing from the space S as shown in FIG. 7, in particular, any molding-flash and dust remained even after sweep action by the air stream can be completely discharged from the space S and, in addition, the resin coating layer 10A can be formed all over the molding.

[0035] Then, the molds are clamped as shown in FIGS. 8 and 9, whereby the resin coating layer 10A can be formed in all parts of the molding 10 as shown, in particular, in FIG. 9. Preferably, the pressurized heating is carried out finally, that is, a secondary heating is performed as shown in FIG. 10, and the molds are opened to release the resin molding from the upper and lower molds.

[0036] While the manufacturing process according to the present invention should preferably be arranged as in the foregoing, it is possible to adopt various equivalents and substitutions. For example, while it has been described that the molds are clamped again after termination of the injection of the fluid coating material, it is possible to clamp the molds again during the injection of the fluid coating material in an event where a material of a short gel time is selected as the fluid coating material, in which case the molding cycle can be remarkably shortened to be contributive to an improvement in the productivity, as will be appreciated.

[0037] In FIG. 14, there is shown an apparatus for practicing the resin-coating process according to a second feature of the present invention, and in FIGS. 15 to 23 the steps of this process are shown.

[0038] This resin-coating apparatus comprises the lower and upper molds 21 and 22, the lower mold 21 is provided on stationary side while the upper mold 22 is made on movable side, and the upper mold 22 is arranged for movement in upward and downward direction on the drawing by means of such cylinder device 31 as an oil pressure cylinder. To this cylinder device 31, a press ram 32, pressure control valve 33, pump 34, press pressure controller 35 and mold-displacement meter 36 are linked. Further, the lower mold 21 is provided with an injecting port 26a for the coating material, so as to be able to inject the coating material 20Aa as a molding resin for forming the resin coating layer 20A through the injecting port 26a for the coating material by means of a coating material supply device 26 including an injection cylinder 37. The coating material supply device 26 comprises a tank 38, a detector 39 for the stroke of the injection cylinder 37, a flow rate control valve 40, a pressure control valve 41 and a pump 41a. Further, the injecting port 26a for the coating material is provided with an opening and closing valve 42. On the other hand, the upper mold 22 is provided with an injecting port 43, so that a fluid supplied through a fluid control valve 44 from a fluid pump 45 can be discharged out of the injecting port 43.

[0039] Now, in manufacturing the resin molded product having the resin coating layer 20A on the molding 20 with the foregoing resin-coating apparatus employed, following steps are executed. That is, the upper mold 22 is first lifted up to form the space S, as shown in FIG. 15 and, in this state, the molding material as a material for the resin molding 20 is placed on the lower mold 21. For the molding material, a thermosetting resin reinforced by glass fibers is employed, and BMC (bulk molding material), SMC (sheet molding material) or the like of unsaturated polyester resin or the like blended with such filler as calcium carbonate, aluminum hydroxide or the like, a hardener, such fibrous reinforcement as glass fibers, carbon fibers or the like, and, as required, a thickening agent, colorant or the like is placed on the lower mold 21. Next, as in FIG. 16, the upper mold 22 is lowered and subjected to the mold clamping, the molding material is heated and compressed, and the molding 20 is formed. Next, the upper mold 22 as well as the molding are slightly moved upward so as to define a slight gap SO between a surface of the molding 20 and the lower mold 21 as in FIG. 17, and, as in FIG. 18, next, the valve 42 is opened to inject the coating material 20Aa consisting of a resin of unsaturated polyesters, vinyl esters, epoxies, acrylics or the like or a mixture resin of them, by means of the coating material supply device 26 through the injecting port 26a for the coating material into the slight gap SO between the front side surface of the molding 20 and the lower mold 21. When the injection of the coating material 20Aa is completed, the valve 42 is closed, the upper mold 22 is also lowered, and the re-compression mold is carried out, as in FIG. 19. After the re-compression mold, the fluid control valve 44 is opened, the fluid is injected from the fluid pump 45 through the injecting port 43, and a pressure is applied to an outer surface of the molding 20, as in FIG. 20. Referring to the fluid employed here, such gaseous member as nitrogen gas, carbon dioxide gas, air or the like or such liquid member as a thermosetting resin of low viscosity, water, oil, alcohol or the like may be employed. In this case, fundamentally, it is optimum to select one which gives no influence on the molding 20 and, in particular, one which does not require such post-treatment as washing or the like. Further, it is desirable that such inert gas as nitrogen gas, carbon dioxide or the like will have a pressure of about 150Kg/cm². With such pressure application to the resin molding by means of the fluid, it is made possible to uniformly pressurize not only flat parts of the molding but also any sloped parts, peripheral parts or the like even when the molding has an uneven surface, and to uniformly bond at all parts the coating material 20Aa to the molding 20 which constitutes a main body of the resin molded product. Thereafter, the fluid control valve 44 is closed, the upper mold 22 is lifted up as in FIG. 21 for the mold opening, and in this state the resin mold product completed is released. In the embodiment shown in FIGS. 14 to 21, the bathtub is shown as an example of the resin molded product. In the bathtub

manufactured here, the resin coating layer 20A can be adhered with a uniform adhesion to the surface of the molding 20 as the main body. In the foregoing manufacture of the bathtub, on the other hand, the upper and lower molds are made to have a temperature of 140 C.

[0040] Referring next to another embodiment of the present invention, the resin coating material 20Aa is injected at the time of the re-compression molding, and then the fluid is injected from the injecting port 43 provided in the upper mold to apply a pressure to the outer surface of the molding 20. That is, in this embodiment, the same steps as those of FIG. 15 to FIG. 18 in the foregoing embodiment are taken but, after the injecting step of the coating material 20Aa as in FIG. 18, the fluid control valve 44 is opened immediately so that the fluid supplied from the fluid pump 45 will be injected from the injecting port 43 to compress the outer surface of the molding 20. In other words, in the present embodiment, the steps of FIGS. 19 and 20 in the foregoing embodiment are replaced by the step of FIG. 22. Accordingly, in the present arrangement, the re-compression molding for forming the resin coating layer 20A can be effectively carried out by means of the pressure feeding of the fluid, and the molding time can be shortened in contrast to the foregoing embodiment. Further, with the practice of the re-compression molding by means of the pressure feeding of the fluid, a uniform pressure of the fluid is made to be applied to all parts of the outer surface made uneven of the molding 20 even in the case of the molding 20 in which an unevenness remains, and a sufficient compression molding pressure can be provided.

[0041] In still another working aspect of the present invention, the arrangement is so made that, upon injecting the coating material 20Aa, the fluid is injected from the injecting port 43 made in the upper mold 22 so as to compress the outer surface of the molding 20. That is, in the present embodiment, the fluid is injected simultaneously with the injection of the coating material 20Aa, and the re-compression molding for forming the resin coating layer 20A is performed by this injection of the fluid. According to this arrangement, the molding time can be further shortened in contrast to the foregoing embodiments, and an excellent compression molding can be realized with a uniform compression force given to uneven outer surface of the molding 20.

[0042] Referring to FIGS. 24 and 25, there is shown an embodiment of the resin-coating apparatus according to a third feature of the present invention, in which apparatus the arrangement is so made that a mold comprising lower mold 51 and upper mold 52, and the resin coating layer 50A can be formed on the side of lower surface 50a of the molding 50 molded between both of the molds.

[0043] The above referred upper mold 52 is provided with a coating material supply device 56 having therein the injecting port 56a for the coating material and opened at its forward tip end which is projected into the molding 50. Further, the lower mold 51 is provided therein with an auxiliary mold 51A made to face the coating material supply device 56 but not to contact with the open tip end of the injecting port 56a. Within the injecting port 56a of the coating material supply device 56, there is provided a plug member 56b movable forward and backward penetratingly through the injection port 56a. At this time, the plug member 56b is elongated to penetrate through the coating material supply device 56 but not to engage at its tip end with the auxiliary mold 51A.

[0044] The above auxiliary mold 51A is provided within a through hole 57 made in the lower mold 51 to be movable forward and backward. Further, tip end portion 56c of the coating material supply device 56 is tapered for engagement with the molding 50.

[0045] Referring in the followings to the operation of the resin-coating apparatus according to the present invention in detail, such molding material as SMC or the like is first placed between the lower and upper molds 51 and 52 in the state where they are opened. At this time, as shown in FIGS. 24 and 26, a top surface 51Aa of the auxiliary mold 51A is positioned to be substantially flush with upper surface 51a of the lower mold 51, the tip end portion 56c of the coating material supply device 56 is positioned not to contact with but close to the auxiliary mold 51A, and the molding 50 is formed with the lower and upper molds 51 and 52 clamped. At this time, a thin layer part 50b is formed in the molding 50, between the tip end portion 56c of the coating material supply device 56 and the top surface 51Aa of the auxiliary mold 51A.

[0046] Next, the clamping pressure for the lower and upper molds 51 and 52 is reduced, the auxiliary mold 51A is moved backward to form a space SB, as shown in FIGS. 25 and 27, the plug member 56b is moved backward in upward direction, and the coating material is injected under a predetermined pressure from the injecting port 56a of the coating material supply device 56. Accompanying this, therefore, the thin layer part of the molding 50 is broken by the injecting pressure of the coating material, as shown in FIG. 28, and the coating material is injected from this part to form the resin coating layer 50A between the bottom surface 50a of the molding 50 and the upper surface of the lower mold 51A.

[0047] As shown in FIG. 28, by the way, there is provided a part 50Ab corresponding to a thickened part at one position, so that, in an event when the bathtub or the like, for example, is to be manufactured, this part corresponding to the thickened part is cut off at a subsequent step so as to form an exhaust port or the like.

[0048] Since, as described in the above, the auxiliary mold 51A provided in the lower mold 51 faces the coating material supply device 56 but is not in contact with the open tip end of the injecting port 56a of this coating material supply device 56, the tip end portion 56c of the coating material supply device 56 can be prevented from being crashed at the time of molding the molding material with the molds clamped for forming the molding 50.

[0049] Accompanying to the above, the backward movement and later forward movement of the plug member 56b of the coating material supply device 56 can be attained in smooth manner, and the operation can be made useful. Further, since the coating material can be injected with the auxiliary mold 51A moved backward and the coating material is caused to be once injected into the space SB occurring behind the auxiliary mold 51A moved backward and thereafter along the bottom surface 50a of the molding 50, the injection of the coating material can be performed in smooth manner.

[0050] Further, since the tip end portion 56c of the coating material supply device 56 is formed as tapered, this tip end portion 56c of the coating material supply device 56 can be easily inserted into the molding 50. At the same time, contacting surface of the molding 50 is urged against contacting part of the coating material supply device by the pressure of the coating material injected, and the coating material can be prevented from intruding to top surface side of the molding 50.

[0051] Referring now to FIGS. 29 to 31 of another working aspect of the resin-coating apparatus in the third feature of the present invention, in which, in addition to the foregoing working aspect of FIGS. 24-28, the auxiliary mold 51A is provided with a recessed part 71 into which a broken portion of the thin layer part 50b is allowed to enter, at the time when the coating material injected from the injecting port 56a of the coating material supply device 56 breaks the thin layer part 50b of the molding 50 and enters along the bottom surface 50a of the molding 50.

[0052] The recessed part 71 is formed with a surface recess 71a of an arcuate shape in section and a female threaded portion 71b continuing to the surface recess 71a. Therefore, as shown in FIG. 29, the portion 50c of the molding 50 enters into this recessed part 71 upon clamping of the lower and upper molds 21 and 22. As shown in FIG. 30, further, the backward movement of the auxiliary mold 51A causes the portion 50c in the recessed part 71 to be separated and moved backward together with the recessed part 71.

[0053] Next, as the coating material is injected, as shown in FIG. 31, the thin layer part 50b of the molding is broken and separated by the injecting pressure, so as to be put into the recessed part 71, whereby this thin layer part 50b is prevented from remaining in the coating material injected along the bottom surface 50a of the molding 50.

[0054] Referring next to FIGS. 32 to 34, there is shown another working aspect of the resin-coating apparatus in the third feature of the present invention. In this third working aspect of the resin-coating apparatus, the tip end portion 56c of the coating material supply device 56 which engages the molding 50 is curved to be convex at a desired curvature and tapered. In this case, engaging part of the molding 50 which faces the tip end portion 56c of the coating material supply device 56 is caused to effectively joined with the tip end portion 56c, so that the coating material can be reliably prevented from leaking to any unnecessary portion, as will be appreciated.

[0055] Referring to FIGS. 35 to 42, there is shown a resin-coating apparatus realizing a fourth feature of the present invention. The resin-coating apparatus of this embodiment is so constituted that the upper mold 82 is provided with an injecting port 86a of the coating material supply device 86, the molding 80 is formed with a mold comprising this upper mold 82 and a lower mold 81, the fluid containing material injected from the injecting port 86a is made to be supplied, passing through the molding 80, to one side surface 80a (bottom side surface in the drawings) of the molding 80, and the resin coating layer 80A may be formed on this one side surface.

[0056] In the upper mold 82 provided with the above injecting port 86a, a groove 91 is formed adjacent to the position where the injecting port 86a is provided, so as to externally enclose the port. In this case, a projection 92 may be provided for the external enclosure, as shown in FIG. 38. It is also preferable to provide such groove 91 or projection 92 in annular shape as in FIG. 39.

[0057] The foregoing groove 91 or projection 92 should preferably be made to have a width of 0.5 to 10mm and a depth or height of 0.5 to 10mm.

[0058] In the resin-coating apparatus of this embodiment, first, such resin molding material as SMC or the like is disposed within the mold in the state where the upper and lower molds 82 and 81 are opened, and the molding 80 is formed with the upper and lower molds 82 and 81 clamped and through the hot compression. In this case, the molding is left in a state not reaching the complete curing. At this time, further, the injecting port 86a is kept in a state inserted in the molding 80.

[0059] Next, the fluid coating material is supplied from this injecting port 86a onto one side surface (lower side surface in FIGS. 35-38), and the resin coating layer 80A is formed. At this time, part of the fluid coating material tends to flow from peripheral part of the tip end of the injecting port 86a into between the upper mold 82 and the molding 80, but the coating material is prevented from intruding onto the other side surface where no resin coating layer 80A is required (upper side surface in the drawings) by the groove 91 or the projection 92 according to the present feature (with the effect of stagnant in the case of the groove 91 or a dam-up in the case of the projection 92).

[0060] As shown in FIG. 40 or 41, further, the groove 91 or projection 92 may be provided closely adjacent to the injecting port 86a or, as shown in FIG. 42, a plurality of the grooves 91 may be provided as mutually spaced. It is of course possible to provide a plurality of the projections as mutually spaced (not shown).

[0061] In FIG. 43, there is shown a resin-coating apparatus for realizing a fifth feature of the present invention. The resin-coating apparatus of this embodiment includes a lower mold 111 which cooperates with the substantially same

upper mold (not shown) as that employed in the respective foregoing embodiments, while the lower mold 111 is provided therein with a cylinder 121 in which an air valve 122 is provided for opening and closing an air flow path within the cylinder 121. A resilient load of a spring 123 is applied to the air valve 122, and a valve rod 124 of the air valve 122 and carrying thereabout the spring 123 is extended in the cylinder. A slit 125 is provided in part of peripheral wall of the cylinder 121 to extend in axial direction, and a stopper 126 projecting from the lower mold 111 is freely engaged in this slit 125. Further, the valve rod 124 is provided with a stopper 127 projecting therefrom for abutting the stopper 126 and with an inward flange 128 bulging inside the cylinder.

[0062] Referring in the followings to the operation of the present embodiment with reference to FIGS. 43 to 48, the molding 110 of the molding material hot-compressed is placed in FIG. 43. Next, the cylinder 121 and air valve 122 having the valve rod 124 are integrally slightly lowered from the state of FIG. 43 to that shown in FIG. 44, and a gap S1 is formed between the lower surface of the molding 110 and the upper surface of the air valve 122. In this state, the stopper 127 is not in engagement with the stopper 126.

[0063] As the cylinder 121 and air valve 122 having the valve rod 124 are further slightly lowered integrally as in FIG. 45, the stopper 127 is locked by the stopper 126, and the air valve 122 having the valve rod 124 is prevented from being further lowered. Thereafter, the cylinder 121 independently descends by a distance allowed by axial length of the slit 125. Here, as the inward flange 128 which constituting a receiving seat for the spring 123 also descends, the stopper 127 is made to be in a state of being held between the stopper 126 and the inward flange 128, and the descend of the cylinder 121 stops. In this state, the air valve 122 is caused by the resiliency of the spring 123 to be separated from the inner periphery of the cylinder 121, and an air flow path S2 is formed.

[0064] Consequently, a supply of air from lower side of the cylinder 121 causes air to flow as indicated by an arrow as shown in FIG. 47, the molding 110 is pushed upward by an air pressure at this time, and a space S0 is formed between the molding and the lower mold 111. As the molding 110 is pushed upward and the space S0 is formed as shown in FIG. 48, the valve rod 134 of the air valve 122 and the cylinder 121 operate in inverse sequence to the above, and they move upward until the upper surface of the air valve 122 comes flush with the upper surface of the lower mold 111. Here, the fluid coating material is injected from, for example, the same injecting nozzle as has been employed in the respective foregoing embodiments into the space S0, and then the resin coating layer can be formed in the space S0. At this time, the air valve 122 is seated on the inner periphery of the cylinder 121 closely tightly so that the operation of air-ejecting nozzle mechanism (not shown) should never be affected by anything which tends to enter into the cylinder 121 and eventually the nozzle mechanism.

[0065] While in the above the disposition of the space S0 for forming the resin coating layer has been referred to with reference to FIGS. 43 to 48, the molding material is placed between the lower mold 151 and the upper mold 152 as in FIG. 49, the molding 150 is formed, the molds are clamped as in FIG. 50 to form the molding 150 through the hot-compression and, thereafter, the space S0 is formed between the molding 150 and the lower mold 151 as shown in FIG. 50 and in such aspect as shown in FIGS. 43 to 48. N1 or N2 is a nozzle path for injecting the coating material, and it is general that, when the injection is made through N1, the nozzle is provided to penetrate through the molding while, when the injection is made through N2, the nozzle is opened towards the space S0. Thus, the coating material is enabled to be supplied from N1 or N2 to the space S0.

[0066] Referring to FIGS. 52 to 55, there is shown a resin-coating apparatus for realizing a sixth feature of the present invention, in which apparatus, too, the arrangement is so made that the fluid coating material is injected through the injecting port 186a of the coating material supply device 186 to one side surface (lower side surface in the drawings) of the molding 180 molded with the split-type mold comprising the lower and upper molds 181 and 182 to form the resin coating layer 180A. The shear edge 191 at side end parts of the split lower and upper molds 181 and 182 is formed into two steps of inside and outside shear edges 191A and 191B, and a space 192 between the lower the upper molds 181 and 182 at the outside shear edge 191B is provided to be smaller than a space 193 at the inside shear edge 191A. Further, the outside shear edge 191B is provided to have a length larger than the length of the inside shear edge 191A.

[0067] In the resin-coating apparatus in the present embodiment, too, such resin molding as SMC or the like is first placed in the state where the lower and upper molds 181 and 182 are opened. Next, the lower and upper molds 181 and 182 are clamped as shown in FIGS. 52 and 53. Next, the coating material is injected onto one side surface 180a of the molding 180 to form the resin coating layer 180A as shown in FIGS. 54 and 55.

[0068] In this case of the resin-coating apparatus according to the present feature, it is made possible that, upon the re-compression with respect to the fluid coating material injected, any leaking of the coating material out of the inside shear edge 191A is prevented by means of the outside shear edge 191B made longer than the inside shear edge 191A.

[0069] It is made thereby possible to control in two stages the amount of the coating material leaking out of the shear edge 191 to be proper, so that the coating material can be prevented from leaking excessively to the exterior, and cleaning work of the lower and upper molds 181 and 182 after the molding can be completed in shorter time. Further, any bubble or dust within the fluid coating material is caused to stay in a space 194 at a step portion between the inside shear edge 191A and the outside shear edge 191B, and absorption of such bubble or dust can be effectively realized at this portion.

[0070] In a working aspect shown in FIG. 56, the inside shear edge 191A and outside shear edge 191B formed to be two steps are so provided that the space 192 between the lower and upper molds 181 and 182 at the outside shear edge 191A is smaller than the space 193 at the inside shear edge 191A.

5 [0071] According to the resin-coating apparatus of this working aspect, therefore, it is made possible to control the fluid coating material leaking out of the inside shear edge 191A upon the re-compression of the coating material injected, at the outside shear edge 191B provided to have the smaller space 192 than the space 193 between the lower and upper molds 181 and 182 at the inside shear edge 191A.

[0072] It should be also appreciated that, with the foregoing arrangement of the present feature, the leaking amount of the coating material out of the shear edge 191 can be controlled in two stages to be proper as has been partly referred to in the above, and the coating material is made not to excessively leak to the exterior so as to render the cleaning of the lower and upper molds after the molding to be completed in a shorter time.

10 [0073] In a working aspect shown in FIG. 57, the inside and outside shear edges 191A and 191B are so formed that the outside shear edge 191B has a larger length than that of the inside shear edge 191A. With the arrangement of FIG. 57, it is made possible that an outflow of the fluid coating material leaking from the inside shear edge 191A upon the re-compression of the coating material injected can be controlled at the outside shear edge 191B made longer than the inside shear edge 191A, whereby the amount of the coating material leaking out of the shear edge 191 is made controllable in two states to be proper and, in addition, the coating material is made not to excessively leak to the exterior, so as to render the cleaning of the lower and upper molds after the molding to be completed in a shorter time.

15 [0074] As the optimum molding material for forming the molding according to the present invention, there is provided a thermosetting molding material constituting a seventh feature of the present invention in order to obtain an excellent resin molded product, that is, the in-mold coated, molded product. The thermosetting molding material employed in the present feature consists of such four components as a thermosetting resin, a radical polymerization initiator, a filler and a curing retarder.

20 [0075] For the thermosetting resin, first, it is possible to employ, irrespective of the type, any ones so long as they are used in general as molding resins of SMC and BMC. In practice, unsaturated polyester resin, (meta)acrylic modified unsaturated polyester resin, phenolic resin, epoxy resin, urethane resin, vinyl ester resin, diallyl phthalate resin or the like may be enumerated.

[0076] For the radical polymerization initiator, such known radical polymerization initiators as ketone peroxides, dialperoxides, hydroperoxides, dialkylperoxides, alkylperesters, percarbonates, peroxy ketals or the like may be used, at an amount of use of 0.1 to 10 parts by weight, preferably 0.5 to 5 parts by weight with respect to 100 parts by weight of the thermosetting resin.

30 [0077] For the filler, any of ones ordinarily employed in SMC, BMC and the like may be employed, examples of which will be calcium carbonate, clay, talc, barium sulfate, aluminum hydroxide, hollow ceramics, hollow glass and the like. A suitable amount of use of them will be 30 to 600 parts by weight with respect to 100 parts by weight of the thermosetting resin. Further, such fibrous reinforcement as glass fibers, carbon fibers, organic fibers or the like may be added as occasion demands, and the reinforcement of 3 to 50 parts by weight with respect to 100 parts by weight of the thermosetting resin should preferably be employed.

[0078] For the curing retarder, on the other hand, it will be possible to use, for example, such SH group-containing moldings as mercaptans of the number of carbon 5 to 20, thioglycols, SH group-containing silicates and the like; one or more of phenolic moldings selected from the group consisting of α -methylstyrene, stilbene, 4-phenoxy styrene, cumene, and 4-methyl-2,4-diphenyl-pentene -1; such monoterpene (terpene of carbon number 10) hydrocarbon as terpinolene, limonene, α -pinene, β -pinene, myrcene or the like; alone or in a mixture of two or more of them.

35 [0079] Curing phenomenon of the thermosetting molding material of the radical polymerization type is represented by a required time until the gelation (which shall be referred to hereinafter as a gelation time GT), time until completion of curing (which shall be referred to hereinafter as the minimum curing time MCT) and their interposition time, that is, a time from the gelation to the completion of the curing (which shall be referred to as the reactivity C-G). However, in order to obtain the resin molded product having an excellent adhesion as has been referred to, it is desirable that a state in which the curing of the molding material has advanced to some extent can be maintained for long, that is, it is desired to prolong the C-G, and it is made possible to have the C-G maintained for more than twice as long as that in ordinary case. This appears to be because the curing retarder catches the radical polymerization initiator to render it to become a relatively stable radical so that the ability of initiating the polymerization becomes weak to advance the polymerization moderately. A suitable amount of use of such curing retarder is 0.1 to 10 parts by weight, preferably 0.2 to 5 parts by weight, with respect to 100 parts by weight of the thermosetting resin. When the curing retarder is less than 0.1 parts by weight, the retarding effect cannot be sufficiently shown and, when the amount of addition exceeds 10 parts by weight, the curing becomes insufficient so as to render it difficult to obtain a high-performance resin molded product.

EXAMPLE 1

[0080] 100 parts of bisphenolic unsaturated polyester resin (commercial name EPOLAC RF-1, manufactured by a Japanese firm K.K. NIPPON SHOKUBAI), 300 parts of aluminum hydroxide, 4 parts of zinc stearate, 1 part of mercaptopropyltrimethoxysilane (curing retarder), 1 part of tert-butyl perbenzoate, 1 part of magnesium oxide and 45 parts of chopped glass were kneaded by a kneader and aged at 40°C for 48 hours, and a thermosetting molding material (BMC-1) was obtained.

EXAMPLE 2

[0081] Except for a use of 1 part of 4-methyl-2,4-diphenyl-pentene-1 in place of mercaptopropyltrimethoxysilane in Example 1, the thermosetting molding material (BMC-2) was obtained in the same manner as in Example 1.

EXAMPLE 3

[0082] Except for a use of 1 part of limonene in place of mercaptopropyltrimethoxysilane in Example 1, the thermosetting molding material (BMC-3) was obtained in the same manner as in Example 1.

COMPARATIVE EXAMPLE

[0083] Except for non-use of the curing retarder, the molding material BMC was obtained in the same manner as in the Examples.

[0084] In order to measure the curing characteristics of these thermosetting molding materials, flat plates 10mm thick and 300x300mm were molded with molding temperature of 130°C for the upper mold and of 120°C for the lower mold.

Result of the measurement at this time is shown in a following Table I.

TABLE 1

	Molding Material	Gel Time (GT sec.)	Minimum Cure Time (MCT sec.)	Reactivity (C-G sec.)
Example 1	BMC-1	80	190	110
Example 2	BMC-2	82	200	118
Example 3	BMC-3	81	220	139
Comp. Ex.	BMC	80	130	50

[0085] Next, using a coating material obtained by mixing through a high speed stirring 100 parts of vinyl ester resin (commercial name EPOLAC RF-1051; by Japanese firm K.K. NIPPON SHOKUBAI), 1 part of zinc stearate, 1 part of tert-butyl perbenzoate and 2 parts of fine powder silica, the resin coating was performed through next manufacturing.

Injection: The molding were opened after the primary curing, and the re-compression was made after the injection of the coating material for the curing.

Mold: Flat plates of 1000x650mm

Mold Temperature: Upper mold 130°C, lower mold 120°C

Molding Pressure: 80kg/cm² commonly for prim. & sec. works

Molding Thickness: 10mm

Coating Thick.: 100μm

Primary Curing: 200 sec., 250 sec., 300 sec., 350 sec.

Secondary Curing: 200 sec.

[0086] The thus obtained resin molded products were subjected to an evaluation of the adhesion at central area CA and corner area SA of the flat-plate molded products by means of a lattice pattern test based on JIS K-5400. Further, their appearance was subjected to visual evaluation, and respective results were as shown in a following Table II. In the case where the primary curing time is less than 200 seconds, the curing of the molding material becomes insufficient, the coating material injected intrudes into the interior of the molding material, and eventually the resin molded product is deteriorated in the appearance. For this reason, the solid state properties were investigated with the primary curing

time made more than 200 seconds.

TABLE II

	Molding Material	Prim. Curing Time (sec.)	Adhesion		Appearance
			CA	SA	
5	Example 1	BMC-1			
	1-1	200	100	100	Good
10	1-2	250	100	100	Good
	1-3	300	100	100	Good
	1-4	350	100	90	Good
15	Example 2	BMC-2			
	2-1	200	100	100	Good
	2-2	250	100	100	Good
	2-3	300	100	100	Good
20	2-4	350	100	95	Good
	Example 3	BMC-3			
	3-1	200	100	100	Bad
25	3-2	250	100	100	Good
	3-3	300	100	100	Good
	3-4	350	100	100	Good
30	Comp. Ex. 1	Comp. BMC			
	1-1	200	100	90	Good
	1-2	250	90	80	Good
	1-3	300	50	30	Good
35	1-4	350	0	0	Good

[0087] As will be clear from the above Table II, it has been found that, in the Example in which the curing retarder is employed according to the present invention, the working time band in which a sufficient adhesion can be obtained reaches 150 seconds (between 200 seconds and 350 seconds) whereas, in the Comparative Example, the adhesion is deteriorated in the case where the coating material is injected after when the primary curing has exceeded 250 seconds. Further, the resin molded products of the foregoing Examples show less fluctuation in the adhesion, and this should be extremely useful also in manufacturing large size resin molded products.

45 EXAMPLES 4-7

[0088] BMC-4 was prepared with α -methylstyrene in place of mercaptopropyltrimethoxysilane in Example 1 (Example 4). Further, ones similarly employing stilbene, 4-phenoxy styrene and cumene as the curing retarder were made respectively BMC-5, BMC-6 and BMC-7 (Examples 5, 6 and 7).

50 [0089] With these molding materials and the foregoing coating material employed, the resin molded products were obtained under the same molding conditions as in the above. The adhesion and appearance were evaluated in the same manner as in the above, and their results were shown in a following Table III.

55

TABLE III

	Molding Material	Prim. Curing Time (sec.)	Adhesion		Appearance
			CA	SA	
Example 4	BMC-4				
4-1		200	100	100	Good
4-2		250	100	100	Good
4-3		300	100	90	Good
4-4		350	100	80	Good
Example 5	BMC-5				
5-1		200	100	100	Good
5-2		250	100	95	Good
5-3		300	100	80	Good
5-4		350	90	65	Good
Example 6	BMC-6				
6-1		200	100	100	Good
6-2		250	100	100	Good
6-3		300	100	100	Good
6-4		350	100	90	Good
Example 7	BMC-7				
7-1		200	100	100	Good
7-2		250	90	80	Good
7-3		300	70	50	Good
7-4		350	50	20	Good

EXAMPLE 8

[0090] Except for a change of 100 parts of bisphenolic unsaturated polyester resin in Example 2 to 70 parts of bisphenolic unsaturated polyester resin and 30 parts of vinyl ester resin (EPOLAC RF-1002G; by Japanese firm K.K. NIPPON SHOKUBAI), BMC-8 was obtained in the same composition as in Example 2 and through the kneading and aging under the conditions referred to in Example 1.

EXAMPLE 9

[0091] Except for a use of 30 parts of urethane modified vinyl ester resin induced from hydroxyethyl methacrylate and 2,4-tolylene diisocyanate, in place of vinyl ester resin in Example 8, BMC-9 was obtained substantially in the same manner as in Example 8.

EXAMPLE 10

[0092] Except for a use of 30 parts of epoxy modified unsaturated polyester resin induced from iso-series unsaturated polyester resin (acid value 20, viscosity 9 poises) and glycidyl methacrylate, in place of vinyl ester resin in Example 8, BMC-10 was obtained substantially in the same manner as in Example 8.

[0093] The resin molded products were obtained with these molding materials and coating material employed under the same molding conditions as in the foregoing. The adhesion and appearance were evaluated in the same manner as in the above, the their results were as shown in a following Table IV.

TABLE IV

	Molding Material	Prim. Curing Time (sec.)	Adhesion		Appearance
			CA	SA	
Example 8	BMC-8				
8-1		200	100	100	Good
8-2		250	100	100	Good
8-3		300	100	100	Good
8-4		350	100	100	Good
Example 9	BMC-9				
9-1		200	100	100	Good
9-2		250	100	100	Good
9-3		300	100	100	Good
9-4		350	100	95	Good
Example 10	BMC-10				
10-1		200	100	100	Good
10-2		250	100	100	Good
10-3		300	100	100	Good
10-4		350	100	90	Good

[0094] As will be clear from the above Tables III and IV, the time band in which a sufficient adhesion can be obtained reaches 100 to 150 seconds in Examples 4 to 10 employing the curing retarder according to the present invention, less fluctuation in the adhesion is seen, and this should be extremely useful in manufacturing, in particular, larger size resin molded products.

EXAMPLES 11-12

[0095] Except for an addition of 2 parts of 4-methyl-2,4-diphenyl-pentene-1 employed in Example 2, BMC-11 was obtained in the same manner as in Example 2. Further, with 4-methyl-2,4-diphenyl-pentene-1 added by 5 parts, BMC-12 was obtained.

[0096] The resin molded products were obtained with these mold compounds and the foregoing coating material employed under the same conditions as in the foregoing, and the adhesion and appearance were evaluated in the same manner as in the above, results of which were as shown in a following Table V.

TABLE V

	Molding Material	Prim. Curing Time (sec.)	Adhesion		Appearance
			CA	SA	
Example 11	BMC-11				
11-1		200	100	100	Bad
11-2		250	100	100	Good
11-3		300	100	100	Good
11-4		350	100	100	Good

TABLE V (continued)

	Molding Material	Prim. Curing Time (sec.)	Adhesion		Appearance
			CA	SA	
Example 12	BMC-12				
12-1		200	100	100	Bad
12-2		250	100	100	Bad
12-3		300	100	100	Good
12-4		350	100	100	Good

[0097] Also in Examples 11 and 12, the time band in which a sufficient adhesion can be obtained has reached above 150 seconds as a result of the use of the curing retarder of the present invention. While some have presented bad appearance, there was seen no fluctuation in the adhesion at all.

[0098] According to an eighth feature of the present invention, the same can be applied to a resin molded product of a deep container shape. As an example of the application, FIGS. 58 and 59 show a bathtub, in which at least a flange part 200a, a bottom surface part 200b of a main body, an extended flange part 200e extending substantially vertically from the flange part 200a, elected surfaces 200c between the bottom part 200b and the flange part 200a, and corner parts 200d formed in the elected surfaces are provided. Further, in this bathtub, a molding of a shape having the elected surfaces 200c large in the length, that is of the deep container shape is formed a thermosetting resin reinforced by glass fibers, and a resin coating layer 200A is provided to cover a front surface of this molding 200.

[0099] Referring further to FIG. 60, there is shown a molding apparatus for the bathtub A according to the present invention, which apparatus employs a mold comprising the stationary type lower mold 201 and the movable type upper mold 202, and to this upper mold 202 there are linked such cylinder device 211 as an oil-pressure cylinder, press ram 212, pressure control valve 213, pump 214, press pressure controller 215 and mold displacement meter 216. The lower mold 201 is provided with an injecting port 206a for the coating material, while a coating material supply device 206 including an injecting cylinder 217 of the coating material 200Aa comprises a tank 218, stroke detecting means 219 for the injecting cylinder 217, flow rate control valve 220, pressure control valve 221 and pump 221a, and an opening and closing valve 222 is provided in the injecting port 206a for the coating material.

[0100] The arrangement and function of these lower and upper molds 201 and 202, coating material supply device 206 and their linking members are the same as those of the resin-coating apparatus in the foregoing working aspect with reference to FIG. 14. Now, in forming the molding 200 with the above apparatus and manufacturing the bathtub having the resin coating layer 200A on the surface of this molding 200, the following steps are executed. That is, as in FIG. 61, first, the upper mold 202 is moved upward to define the space S, and in this state the molding material M constituting the material for the molding 200 is placed on the lower mold 201. Here, the fiber reinforced thermosetting resin can be employed as the molding material, in which an unsaturated polyester resin or the like, such filler as calcium carbonate or aluminum hydroxide, such fibrous reinforcement as glass fibers or carbon fibers, and such additives as a thickening agent, colorant and the like as occasion demands are blended, and the molding material is loaded on the lower mold 201 as the BMC (bulk molding material), SMC (sheet molding material) or the like. Next, as in FIG. 62, the upper mold 202 is lowered to have the mold clamped and the molding material M compressed under a pressure, and the molding 200 is formed. Then, the upper mold 202 is slightly lifted up as in FIG. 63, the slight space S1 is formed thereby between a surface of the molding 200 and the lower mold 201, and then the valve 222 is opened as in FIG. 64 to have the coating material 200Aa consisting of a resin of unsaturated polyester, vinyl ester, epoxy, acrylic or the like series injected from the injecting port 206a through the coating material supplying device 206 into the slight space S1 between the surface of the molding 200 and the lower mold 201. While at this time the upward movement of the upper mold 202 is effective to produce the space S1 of an identical length to upward moving distance L to the upper mold 202 with respect to such horizontal plane parts as the flange part 200a, bottom surface part 200b, the gap with respect to slanted surface parts of the elected surfaces 200c other than the horizontal plane parts between the respective corner parts 200d is represented by $L \times \cos \theta$, which is shorter than L, as seen in FIG. 67. In molding the bathtub, therefore, the coating material 200Aa charged in portions facing the horizontal plane parts of the flange parts 200a and main-body bottom surface part 200b is made larger in charged thickness than that of the coating material 200Aa at other portions than the horizontal plane parts, and a sufficient reinforcement can be attained.

[0101] When the injection of the coating material 200Aa is completed in this manner, the valve 222 is closed as in FIG. 65, and the re-compression molding is carried out. Subsequent to this re-compression molding, the upper mold 202 is lifted up as in FIG. 66 to open the molds, and in this state the bathtub is taken out. In this case, it is made easier to perform the forming work of the exhaust hole with respect to the bathtub thus taken out, so long as the position of the

injecting port 206a for the coating material of the coating material supply device 206 is made to correspond to the position of the exhaust hole of the bathtub and the arrangement is so made as to provide, for example, the coating material supply device 206 at the position of the upper mold 202 for forming the hole in the molding 200 itself as in FIGS. 25 to 45 or FIGS. 52 to 57. In the bathtub manufactured in this way, the resin coating layer 200A is formed excellently on the surface of the molding 200, and this resin coating layer 200A is made thicker at such horizontal plane portions as the flange parts 200a and main-body bottom surface part 200b than such other portions as the elected surfaces 200c. Measurement of the thickness at respective portions of the resin coating layer 200A in one of the products formed in the foregoing manner has shown that the flange part 200a was about 500 μ m, the main-body bottom surface 200b was about 700 μ m, the corner parts 200d were about 80 μ m and the elected surfaces 200c between the respective corner parts were about 150 μ m. While there occurs a slight difference in the thickness between the flange parts 200a and the main-body bottom surface part 200b both forming the horizontal plane parts, this is due to a fluctuation occurred depending on the molding conditions or the like, and the difference to such extent gives no influence on the increase of strength. Further, in order to improve the strength at the corner parts 200d, for example, parts of the molding 200 corresponding to the corner parts 200d may be made thicker so as to enlarge an amount of shrink of the molding 200. It is also preferable to render the thickness of the resin coating layer 200A at such horizontal plane parts as the flange parts 200a and main-body bottom surface part 200b to be larger more than twice as large as that of other parts.

[0102] In addition, it is also possible to employ a coating material 200Aa to which such inorganic substance as a mica powder, glass powder or the like or a metal powder of copper, nickel, aluminum or the like is added, so that the coating material will be colored or provided with an effect.

Claims

1. A process for forming a resin molded product including a molded body (10;20;50;80;110;150;180;200) and a molded coating (10A;20A;50A;80A; 180A;200A), the process employing male and female mold sections (11;21; 51;111;151;181;201;12;22;52;82;152;182;202) separable relative to one another along a clamping direction, the male and female mold sections including opposing male and female mold surfaces, respectively, the process comprising the steps of (A) compressing a resin molding material within a first molding space (S) defined between both mold surfaces to form the molded body (10;20...), (B) partially separating the male and female mold sections to form a second molding space (S0) between one surface of the molded body and one of the mold surfaces prior to complete curing of the molded body, (C) injecting a resin coating material into the second molding space to mold the coating on the one surface of the molded body, and (D) clamping again the male and female mold sections together to effect further curing under a pressure of the molded product, characterized in that the process further comprises the steps of, prior to the step (A), providing to each of the opposing male and female mold surfaces an outer peripheral surface region (11b,12b) tapered with respect to the clamping direction, the outer peripheral surface regions of both mold surfaces facing one another, and, prior to the step (C), flowing a gas into and out of the second molding space (S0) to discharge foreign matter from the second molding space; and in that, in the step (A), the molded body (10;20...) occupies the portion of the first molding space (S) disposed between the tapered outer peripheral surface regions (11b,12b), and, in the step (C), the resin coating material is injected also in the portion of the second molding space (S0) disposed between the molded body (10;20...) and the tapered outer peripheral surface region (11b,12b) of the one mold surface.
2. The process according to claim 1, characterized in that, in the step (C), the injection of the resin coating material into the second molding space (S0) is performed at a position corresponding to a position of a hole to be provided in the molded product.
3. The process according to claim 1, characterized in that, in the step (C), part of the resin coating material injected into the second molding space (S) is caused to leak out of the second space at the tapered part (11b,12b), and thereafter the male and female mold sections (11,12) are clamped for the complete curing.
4. The process according to claim 1, characterized in that, in the step (D), the male and female mold sections (21,22) are clamped again after completion of the injection of the step (C) for a uniform molding of the coating (20A).
5. The process according to claim 1, characterized in that, in the step (C), the resin coating material of a short gel time is used, and both mold sections (11,12) are clamped again while the resin coating material is being injected.
6. The process according to claim 1, characterized in that, after the step (D), a fluid is injected from an injecting port (43) provided in one of the male and female mold sections (21,22) on the side facing the other surface of the mold body (20), to apply a pressure to the other surface of the molded body (20) for uniform bonding between the molded

body (20) and the coating material (20A).

7. The process according to claim 1, characterized in that, after the step (C), a fluid is injected from an injecting port (43) provided in one of the male and female mold sections (21,22) on the side facing the other surface of the molded body (20), to apply a pressure to the other surface of the molded body (20) for uniform bonding between the molded body (20) and the coating material (20A).

8. The process according to claim 1, characterized in that, in the step (C), the coating material is injected from an injecting port (26a) provided in one of the male and female mold sections (21,22), and a fluid is injected from a further injecting port (43) provided in the other of the mold sections (21,22) substantially simultaneously with the injection of the coating material to apply a pressure to the other surface of the mold body (20) than the surface facing the coating material (20A).

9. An apparatus for forming a resin molded product including a molded body and a molded coating, the apparatus comprising male and female mold sections (51,52) having respective male and female mold surfaces and mutually separable along a clamping direction, and a coating-material injecting means (56) disposed in one of the male and female mold sections and including a tip end (56c), the mold sections being driven to define a first molding space between both mold surfaces of the mold sections for forming the molded body and a second molding space between the molded body and the mold surface of the one mold section for forming the molded coating, characterized in that:

each of the male and female mold surfaces defines an outer peripheral surface region tapered with respect to the clamping direction of the male and female mold sections (51,52),

the injecting means (56) includes an injection port (56a) extending through the tip end (56c) and communicable with the first molding space, and

the apparatus further comprises an auxiliary mold (51A) movably mounted in the other of the male and female mold sections (51,52) in mutual facing but separated relationship with the tip end (56c) of the injecting means (56), and a plug member (56b) movably mounted in the injection port (56a) for opening and closing the injection port.

10. The apparatus according to claim 9, characterized in that the auxiliary mold (51A) is retractable with respect to the one of the male and female mold sections (51,52).

11. The apparatus according to claim 9, characterized in that the tip end (56c) of the coating-material injecting means (56) is tapered.

12. The apparatus according to claim 9, characterized in that the tip end (56c) of the coating-material injecting means (56) is disposed close to the auxiliary mold (51A) for extending partways through the molded body (50) in the first molding space, so as to form a thin part (50b) in the molded body.

13. The apparatus according to claim 12, characterized in that the auxiliary mold (51A) is provided with a recess (71) into which the thin part (50b) of the molded body (50) enters when the coating material is injected from the injecting port (56a) of the coating-material injecting means (56) to urge the thin part (50b) to be broken off from the molded body.

14. The apparatus according to claim 9, characterized in that the mold surface of the one of the male and female mold sections (81,82) is provided with means (91;92) surrounding the tip end of the coating-material injecting means (86) for restraining a flowing of the coating material therepast.

15. The apparatus according to claim 14, characterized in that the flow restraining means is one of a groove (91) and a projection (92).

16. The apparatus according to claim 9, characterized in that an air ejecting means is provided on the one (111) of the male and female mold sections for ejecting air into the first molding space, the air ejecting means includes a cylinder (121) movable towards and away from the first molding space, and a valve (122) independently movable within the cylinder for opening and closing a flow path (S2) in the cylinder, the air ejecting means being opened to eject air urging the molded body (110) in the first molding space against the other of the male and female mold section.

17. The apparatus according to claim 9, characterized in that outermost peripheral ends of the male and female mold sections (181,182) form a leak-resisting space (191) communicating with the tapered surface region, the leak-resisting space formed between stepped portions of the male and female mold sections, each of the stepped portions including inner and outer shear edges (191A,191B), the inner shear edges (191A) facing one another to form a first section (193) of the leak-resisting space, the outer shear edges (191B) facing one another to form a second section (192) of the leak-resisting space which is narrower than the first section, the first and second sections arranged so that leaking material from the molding space enters the first section before entering the second section.
18. The apparatus according to claim 9, characterized in that outermost peripheral ends of the male and female mold sections (181,182) form a leak-resisting space (191) communicating with the tapered surface region, the leak-resisting space formed between stepped portions of the male and female mold sections, each of the stepped portions including inner and outer shear edges (191A,191B), the inner shear edges (191A) facing one another to form a first section of the leak-resisting space, the outer shear edges (191B) facing one another to form a second section of the leak-resisting space which is longer than the first section, the first and second sections arranged so that leaking material from the molding space enters the first section before entering the second section.

Patentansprüche

1. Verfahren zur Formung eines aus Kunstharz geformten Produktes, umfassend einen geformten Körper (10; 20; 50; 80; 110; 150; 180; 200) und eine geformte Beschichtung (10A; 20A; 50A; 80A; 180A; 200A), wobei der Prozeß positive und negative Formteile (11; 21; 51; 111; 151; 181; 201; 12; 22; 52; 82; 152; 182; 202) umfaßt, die in einer Klemmrichtung voneinander getrennt werden können, wobei der positive und der negative Formteil einander gegenüberliegende positive bzw. negative Formoberflächen aufweisen und der Prozeß folgende Schritte umfaßt: (A) Komprimieren eines Kunstharz-Formwerkstoffs in einem ersten Formraum (S), der zwischen den beiden Formoberflächen festgelegt ist, um den geformten Körper (10; 20...) zu bilden, (B) teilweises Trennen des positiven und negativen Formteils, um einen zweiten Formraum (SO) zwischen einer Oberfläche des geformten Körpers und einer der Formoberflächen zu formen, bevor der geformte Körper ausgehärtet ist, (C) Einspritzen eines Kunstharz-Beschichtungsstoffes in den zweiten Formraum, um die Beschichtung auf der einen Oberfläche des geformten Körpers zu formen, und (D) erneutes Verschließen des positiven und des negativen Formteils, um das weitere Aushärten des geformten Produkts unter Druck zu bewirken, **dadurch gekennzeichnet**, daß der Prozeß weiter folgende Schritte umfaßt: vor Schritt (A), Bereitstellen einer äußeren peripheren Oberflächenzone (11b, 12b) an jeder der einander gegenüberliegenden positiven und negativen Formoberflächen, die in Bezug zur Klemmrichtung konisch verlaufen, wobei die äußeren peripheren Oberflächenzonen beider Formoberflächen einander gegenüber liegen, und, vor Schritt (C), Durchströmen des zweiten Formraums (SO) mit Gas, um Fremdstoffe aus dem zweiten Formraum zu entfernen; sowie dadurch, daß in Schritt (A) der geformte Körper (10; 20...) den Teil des ersten Formraums (S) einnimmt, der zwischen den konischen äußeren peripheren Oberflächenzonen (11b, 12b) liegt, und daß in Schritt (C) der Kunstharz-Beschichtungsstoff auch in den Teil des zweiten Formraums (SO) eingespritzt wird, der zwischen dem geformten Körper (10; 20...) und der konischen äußeren peripheren Oberflächenzone (11b, 12b) der einen Formoberfläche liegt.
2. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß in Schritt (C) die Einspritzung des Kunstharz-Beschichtungsstoffes in den zweiten Formraum (SO) an einer Stelle erfolgt, die der Stelle einer in dem geformten Produkt vorgesehenen Öffnung entspricht.
3. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß in Schritt (C) das Auslaufen eines Teils des in den zweiten Formraum (S) eingespritzten Kunstharz-Beschichtungsstoffes an dem konischen Teil (11b; 12b) aus dem zweiten Raum erzwungen wird und anschließend der positive und der negative Formteil (11, 12) zur vollständigen Aushärtung geschlossen werden.
4. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß in Schritt (D) der positive und der negative Formteil (21, 22) nach der Einspritzung aus Schritt (C) wieder verschlossen werden, um eine gleichmäßige Formung der Beschichtung (20A) zu erzielen.
5. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß in Schritt (C) der Kunstharz-Beschichtungsstoff mit kurzer Gelierzeit verwendet wird und beide Formteile (11, 12) während der Einspritzung des Kunstharz-Beschichtungsstoffes wieder verschlossen werden.

6. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß nach Schritt (D) über eine Einspritzöffnung (43) in einem positiven bzw. negativen Formteil (21, 22) auf der Seite, die der anderen Oberfläche des geformten Körpers (20) gegenüberliegt, eine Flüssigkeit eingespritzt wird, um auf die andere Oberfläche des geformten Körpers (20) einen Druck auszuüben, so daß eine gleichmäßige Verbindung zwischen dem geformten Körper (20) und dem Beschichtungsstoff (20A) erreicht wird.
7. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß nach Schritt (C) über eine Einspritzöffnung (43) in einem positiven bzw. negativen Formteil (21, 22) auf der Seite, die der anderen Oberfläche des Formkörpers (20) gegenüberliegt, eine Flüssigkeit eingespritzt wird, um auf die andere Oberfläche des geformten Körpers (20) einen Druck auszuüben, so daß eine gleichmäßige Verbindung zwischen dem geformten Körper (20) und dem Beschichtungsstoff (20A) erreicht wird.
8. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß in Schritt (C) der Beschichtungsstoff über eine Einspritzöffnung (26a) eingespritzt wird, die in einem positiven bzw. negativen Formteil (21, 22) vorgesehen ist, und eine Flüssigkeit aus einer weiteren Einspritzöffnung (43) eingespritzt wird, die in dem jeweils anderen Formteil (21, 22) vorgesehen ist, im wesentlichen gleichzeitig mit der Einspritzung des Beschichtungsstoffes, um auf die andere Oberfläche des geformten Körpers (20), die nicht dem Beschichtungsstoff (20A) gegenüberliegt, einen Druck auszuüben.
9. Vorrichtung zum Formen eines Kunstharz-Formproduktes, umfassend einen geformten Körper und eine geformte Beschichtung, wobei die Vorrichtung positive und negative Formteile (51,52) umfaßt, mit den jeweiligen positiven und negativen Formoberflächen, die voneinander in einer Klemmrichtung trennbar sind, und ein Beschichtungsstoff-Einspritzmittel (56), das in einem positiven bzw. negativen Formteil angeordnet ist und ein spitzes Ende (56c) umfaßt, wobei die Formteile so angetrieben werden, daß sie einen ersten Formraum zwischen den beiden Formoberflächen der Formteile bilden, in dem der geformte Körper gebildet wird, und einen zweiten Formraum zwischen dem geformten Körper und der Formoberfläche des einen Formteils, um die geformte Beschichtung zu bilden, **dadurch gekennzeichnet**, daß: die positive und die negative Formoberfläche jeweils eine äußere periphere Oberflächenzone festlegen, die, bezogen auf die Klemmrichtung des positiven und negativen Formteils (51, 52), konisch verläuft, das Einspritzmittel (56) eine Einspritzöffnung (56a) umfaßt, die durch das spitze Ende (56c) verläuft und zu dem ersten Formraum eine Verbindung herstellen kann und die Vorrichtung weiter eine Hilfsform (51A) umfaßt, die beweglich in dem jeweils anderen Teil des positiven bzw. negativen Formteils (51, 52) montiert ist, dem spitzen Ende (56c) des Einspritzmittels (56) gegenüberliegend, jedoch von diesem getrennt, und ein Stopfenelement (56b), das beweglich in der Einspritzöffnung (56a) eingebaut ist, um die Einspritzöffnung zu öffnen bzw. zu verschließen.
10. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet**, daß die Hilfsform (51A), bezogen auf das positive bzw. negative Formteil (51, 52), zurückziehbar ist.
11. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet**, daß das spitze Ende (56c) des Beschichtungsstoff-Einspritzmittels (56) konisch ist.
12. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet**, daß das spitze Ende (56c) des Beschichtungsstoff-Einspritzmittels (56) dicht an der Hilfsform (51A) angeordnet ist, um teilweise durch den geformten Körper (50) in dem ersten Formraum zu verlaufen, so daß in dem geformten Körper ein dünner Teil (50b) geformt wird.
13. Vorrichtung nach Anspruch 12, **dadurch gekennzeichnet**, daß die Hilfsform (51A) mit einer Aussparung (71) versehen ist, in welche der dünne Teil (50b) des geformten Körpers (50) eintritt, wenn der Beschichtungsstoff über die Einspritzöffnung (56a) des Beschichtungsstoff-Einspritzmittels (56) eingespritzt wird, so daß das dünne Teil (50b) zwangsweise von dem geformten Körper abgebrochen wird.
14. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet**, daß die Formoberfläche eines positiven bzw. negativen Formteils (81, 82) mit Mitteln (91, 92) ausgestattet ist, die das spitze Ende des Beschichtungsstoff-Einspritzmittels (86) umgeben, um ein Vorbeiströmen des Beschichtungsstoffes an diesem zu begrenzen.
15. Vorrichtung nach Anspruch 14, **dadurch gekennzeichnet**, daß das Strömungsbegrenzungsmittel aus einer Rille (91) und einem Vorsprung (92) besteht.
16. Vorrichtung nach Anspruch 9, **dadurch gekennzeichnet**, daß ein Lufteinspritzmittel an einem (111) der positiven

bzw. negativen Formteile vorgesehen ist, um Luft in den ersten Formraum einzuspritzen, wobei das Luft einspritzmittel einen Zylinder (121) umfaßt, der zu dem und von dem ersten Formraum weg bewegt werden kann, und ein Ventil (122), das innerhalb des Zylinders frei beweglich ist, zum Öffnen und Schließen eines Strömungsweges (52) in dem Zylinder, das Luft einspritzmittel geöffnet wird, um Luft einzuspritzen, womit der geformte Körper (110) in dem ersten Formraum gegen das andere positive bzw. negative Formteil gepreßt wird.

17. Vorrichtung nach Anspruch 9, dadurch gekennzeichnet, daß die äußersten peripheren Enden des positiven und des negativen Formteils (181, 182) einen leckdichten Raum (191) bilden, der eine Verbindung zu dem konischen Oberflächenbereich hat, der leckdichte Raum zwischen den abgestuften Teilen des positiven und des negativen Formteils gebildet wird, jeder der abgestuften Teile innere und äußere Scherkanten (191A, 191B) umfaßt, die inneren Scherkanten (191A) einander gegenüberliegen, um einen ersten Teil (193) des leckdichten Raums zu bilden, die äußeren Scherkanten (191B) einander gegenüberliegen, um einen zweiten Teil (192) des leckdichten Raums zu bilden, der schmaler als der erste Teil ist, wobei der erste und der zweite Teil so angeordnet sind, daß Material, das aus dem Formraum austritt, zuerst in den ersten Teil läuft, bevor es in den zweiten Teil läuft.

18. Vorrichtung nach Anspruch 9, dadurch gekennzeichnet, daß die äußersten peripheren Enden des positiven und negativen Formteils (181, 182) einen leckdichten Raum (191) bilden, der mit dem konischen Oberflächenbereich in Verbindung steht, wobei der leckdichte Raum zwischen abgestuften Teilen des positiven und negativen Formteils geformt wird, jeder abgestufte Teil innere und äußere Scherkanten (191A, 191B) aufweist, die inneren Scherkanten (191A) einander gegenüber liegen, um einen ersten Teil des leckdichten Raums zu bilden, die äußeren Scherkanten (191B) einander gegenüber liegen, um einen zweiten Teil des leckdichten Raums zu bilden, der länger als der erste Teil ist, wobei der erste und der zweite Teil so angeordnet sind, daß aus dem Formraum austretendes Material zuerst in den ersten Teil läuft, bevor es in den zweiten Teil läuft.

Revendications

1. Procédé pour former un article moulé en résine incluant un corps moulé (10;20;50;80;110;150;180;200) et un revêtement moulé (10A;20A;50A;80A;180A;200A), le procédé utilisant des sections de moule mâle et femelle (11;21;51; 111;151;181;201;12;22;52;82;152;182;202) séparables l'une de l'autre dans une direction de serrage, les sections de moule mâle et femelle comprenant respectivement des surfaces de moule mâle et femelle opposées, le procédé comprenant les étapes consistant à (A) comprimer un matériau de moulage formé d'une résine dans un premier espace de moulage (F) défini entre deux surfaces du moule de manière à former le corps moulé (10;20...), (B) séparer partiellement les sections de moule mâle et femelle pour former un second espace de moulage (S0) entre une surface du corps moulé et l'une des surfaces du moule avant le durcissement complet du corps moulé, (C) injecter un matériau de revêtement formé d'une résine dans le second espace de moulage pour mouler le revêtement sur une surface du corps moulé, et (D) serrer à nouveau les sections de moule mâle et femelle conjointement pour réaliser un durcissement complémentaire sous pression de l'article moulé, caractérisé en ce que le procédé comprend en outre l'étape intervenant avant l'étape (A) et consistant à prévoir sur chacune des surfaces de moule mâle et femelle opposées une partie de surface périphérique extérieure (11b,12b) se rétrécissant par rapport à la direction de serrage, les régions périphériques extérieures des deux surfaces de moule se faisant face et, avant l'étape (C), introduire un gaz dans le second espace de moulage (S0) et l'en faire ressortir pour évacuer une substance étrangère du second espace de moulage; et en ce que lors de l'étape (A), le corps moulé (10;20;...) occupe la partie du premier espace de moulage (S) disposée entre les régions périphériques extérieures de surface de forme rétrécie (11b,12b), et lors de l'étape (C), on injecte le matériau de revêtement formé d'une résine également dans la partie du second espace de moulage (S0) situé entre le corps moulé (10;20...) et la région périphérique extérieure de forme rétrécie (11b,12b) d'une surface du moule.
2. Procédé selon la revendication 1, caractérisé en ce que, lors de l'étape (C), l'injection du matériau de revêtement formé d'une résine dans le second espace de moulage (S0) est réalisée dans une position correspondant à une position d'un trou devant être prévu dans l'article moulé.
3. Procédé selon la revendication 1, caractérisé en ce que, lors de l'étape (C), une partie du matériau de revêtement formé d'une résine injectée dans le second espace de moulage (S) est amenée à fuir hors du second espace de moulage au niveau de la partie de forme rétrécie (11b,12b), et qu'ensuite on serre les sections de moule mâle et femelle pour le durcissement complet.
4. Procédé selon la revendication 1, caractérisé en ce que lors de l'étape (D), on serre à nouveau les sections de moule mâle et femelle (21,22) une fois achevée l'injection lors de l'étape (C), pour un moulage uniforme du revête-

ment (20A).

5. Procédé selon la revendication 1, caractérisé en ce que lors de l'étape (C), qu'on utilise le matériau de revêtement formé de résine, qui reste pendant une brève durée à l'état de gel et que l'on serre à nouveau les deux sections de moule (11,12) tout en injectant le matériau de revêtement formé en résine.

6. Procédé selon la revendication 1, caractérisé en ce qu'après l'étape (D), un fluide est injecté depuis un orifice d'injection (43) prévu dans l'une des sections de moule mâle et femelle (21,22) sur le côté tourné vers l'autre surface du corps (20) du moule pour l'application d'une pression à l'autre surface du corps moulé (20) pour une liaison uniforme entre le corps moulé (20) et le matériau de revêtement (20A).

7. Procédé selon la revendication 1, caractérisé en ce qu'après l'étape (C), un fluide est injecté à partir d'un orifice d'injection (43) prévu dans les sections de moule mâle et femelle (21,22) sur le côté tourné vers l'autre surface du corps moulé (20), pour l'application d'une pression à l'autre surface du corps moulé (20) pour l'établissement d'une liaison uniforme entre le corps moulé (20) et le matériau de revêtement (20A).

8. Procédé selon la revendication 1, caractérisé en ce que lors de l'étape (C), le matériau de revêtement est injecté à partir d'un orifice d'injection (26a) prévu dans l'une des sections de moule mâle et femelle (21,22) et qu'un fluide est injecté à partir d'un autre orifice d'injection (43) prévu dans l'autre des sections de moule (21,22) sensiblement en même temps que s'effectue l'injection du matériau de revêtement, pour l'application d'une pression sur la surface du corps de moule (20), autre que la surface, tournée vers le matériau de revêtement (20A).

9. Appareil pour former un article moulé en résine comprenant un corps moulé et un revêtement moulé, l'appareil comprenant des sections de moule mâle et femelle (51,52) comportant des surfaces respectives de moule mâle et femelle et pouvant être séparées l'une de l'autre dans une direction de serrage, et des moyens (58) d'injection du matériau de revêtement disposés dans une première des sections de moule mâle et femelle et comprenant une extrémité en forme de pointe (56c), les sections de moule étant actionnées de manière à définir un premier espace de moulage entre les deux surfaces des sections de moule de manière à former le corps moulé, et un second espace de moulage entre le corps moulé et la surface de la première section de moule pour former le revêtement moulé, caractérisé en ce que :

chacune des surfaces de moule mâle et femelle définit une surface périphérique extérieure qui se rétrécit par rapport à la direction de serrage des sections de moule mâle et femelle (51,52), les moyens d'injection (56) comprennent un orifice d'injection (56a) qui s'étend à travers l'extrémité pointue (56c) et peut communiquer avec le premier espace de moulage, et l'appareil comporte en outre un moule auxiliaire (51A) monté de manière à être déplaçable dans l'autre des sections de moule mâle et femelle (51,52) qui se font face, mais en étant dans une position séparée de l'extrémité en forme de pointe (56c) des moyens d'injection (56c), et un élément de broche (56b) monté de manière à être déplaçable dans l'orifice d'injection (56c) pour l'ouverture et la fermeture de l'orifice d'injection.

10. Appareil selon la revendication 9, caractérisé en ce que le moule auxiliaire (51A) est rétractable par rapport à l'une des sections de moule mâle et femelle (51,52).

11. Appareil selon la revendication 9, caractérisé en ce que l'extrémité en forme de pointe (56c) des moyens (56) d'injection du matériau de revêtement possède une forme rétrécie.

12. Appareil selon la revendication 9, caractérisé en ce que l'extrémité en forme de pointe (56c) des moyens (56) d'injection du matériau de revêtement est disposée à proximité du moule auxiliaire (51A) de manière à s'étendre partiellement à travers le corps moulé (50) dans le premier espace de moulage, de manière à former une partie mince (50b) dans le corps moulé.

13. Appareil selon la revendication 12, caractérisé en ce que le moule auxiliaire (51A) comporte un renforcement (71) dans lequel la partie mince (50b) du corps moulé (50) pénètre lorsque le matériau de revêtement est injecté à partir de l'orifice d'injection (56c) des moyens (56) d'injection du matériau de revêtement, de manière à repousser la partie mince (50b) de manière à ce qu'elle se casse à partir du corps moulé.

14. Appareil selon la revendication 9, caractérisée en ce que la surface de moule de l'une des sections de moule mâle et femelle (81,82) comporte des moyens (91,92) entourant l'extrémité en forme de pointe des moyens (86) d'inject-

tion du matériau de revêtement afin d'empêcher un écoulement du matériau de revêtement à ce niveau.

15. Appareil selon la revendication 14, caractérisé en ce que les moyens de limitation de l'écoulement sont formés par une gorge (91), et une partie saillante (92).

5

16. Appareil selon la revendication 9, caractérisé en ce que des moyens d'éjection d'air sont prévus sur l'une (111) des sections de moule mâle et femelle pour éjecter de l'air dans le premier espace de moulage, les moyens d'éjection d'air comprenant un cylindre (121) pouvant être rapproché et écarté du premier espace de moulage, et une soupape (122) déplaçable de façon indépendante dans le cylindre pour l'ouverture et la fermeture d'un trajet d'écoulement (S2) dans le cylindre, les moyens d'éjection d'air étant ouverts de manière à éjecter de l'air refoulant le corps moulé (110) dans le premier espace de moulage contre l'autre des sections de moule mâle et femelle.

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17. Appareil selon la revendication 9, caractérisé en ce que des extrémités périphériques les plus extérieures des sections de moule mâle et femelle (181,182) forment un espace (191) s'opposant à une fuite, et communiquent avec la région de surface de forme rétrécie, l'espace s'opposant à une fuite étant formé entre des parties étagées des sections de moule mâle et femelle, chacune des parties étagées comprenant des bords de cisaillement intérieur et extérieur (291a,191b), les bords intérieurs de cisaillement (191A) étant tournés l'un vers l'autre de manière à former une première section (193) de l'espace s'opposant à une fuite, les bords extérieurs de cisaillement (191B) étant tournés l'un vers l'autre de manière à former une seconde section (192) de l'espace s'opposant à une fuite, qui est plus étroite que la première section, les première et seconde sections étant agencées de telle sorte qu'un matériau, qui fuit à partir de l'espace de moulage, pénètre dans la première section avant de pénétrer dans la seconde section.

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18. Appareil selon la revendication 9, caractérisé en ce que les extrémités périphérique les plus extérieures des sections de moule mâle et femelle (181,182) forment un espace (191) s'opposant à une fuite, et communiquent avec la région de surface de forme rétrécie, l'espace s'opposant à une fuite étant formé entre des parties étagées des sections de moule mâle et femelle, chacune des parties étagées comprenant des bords de cisaillement intérieur et extérieur (191A,191B), les bords intérieurs de cisaillement (191A) étant tournés l'un vers l'autre de manière à former une première section de l'espace s'opposant à une fuite, les bords extérieurs de cisaillement (191B) étant tournés l'un vers l'autre de manière à former une seconde section de l'espace s'opposant à une fuite, qui est plus longue que la première section, les première et seconde section étant agencées de telle sorte qu'un matériau, qui fuit à partir de l'espace de moulage, pénètre dans la première section avant de pénétrer dans la seconde section.

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FIG. 1

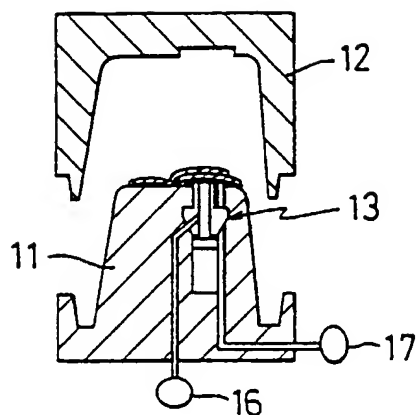


FIG. 2

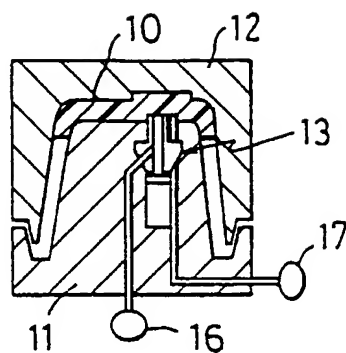


FIG. 3

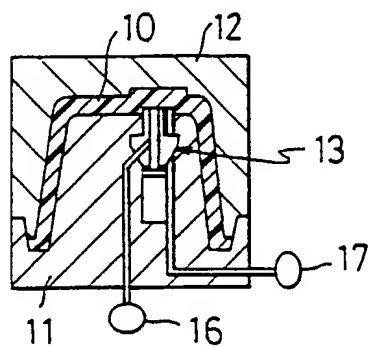


FIG. 4

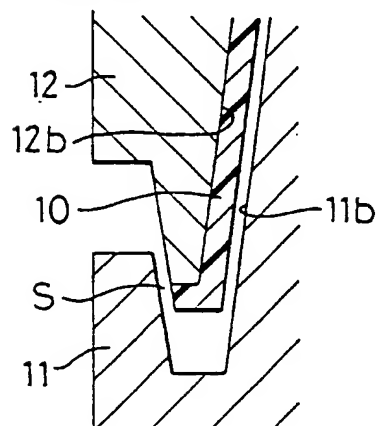


FIG. 5

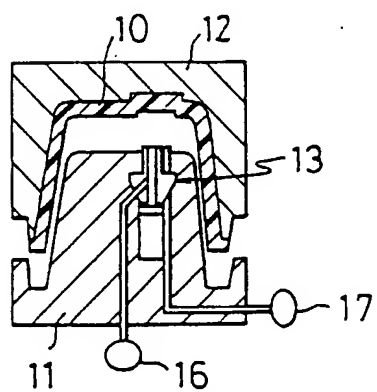


FIG. 6

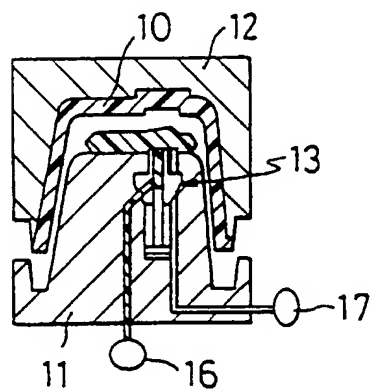


FIG. 7

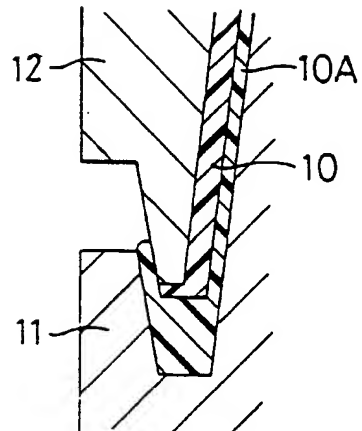


FIG. 8

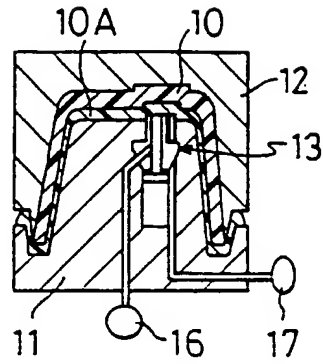


FIG. 10

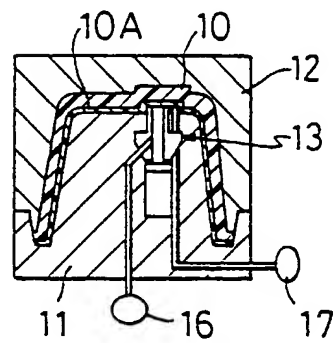


FIG. 9

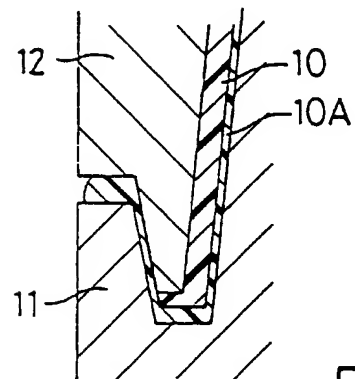


FIG. 11

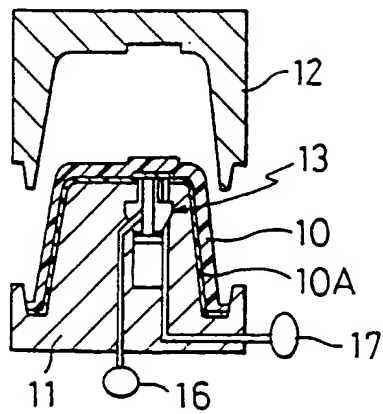


FIG. 12

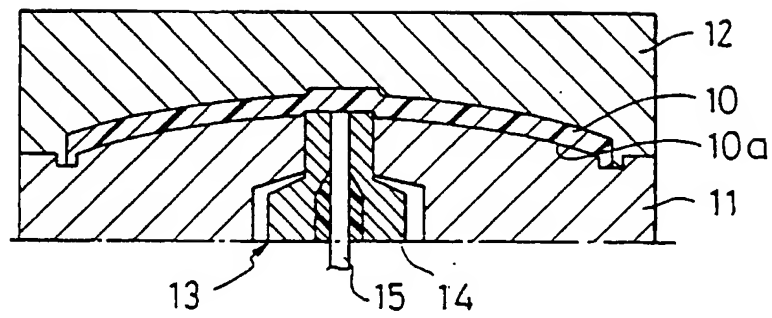


FIG. 13

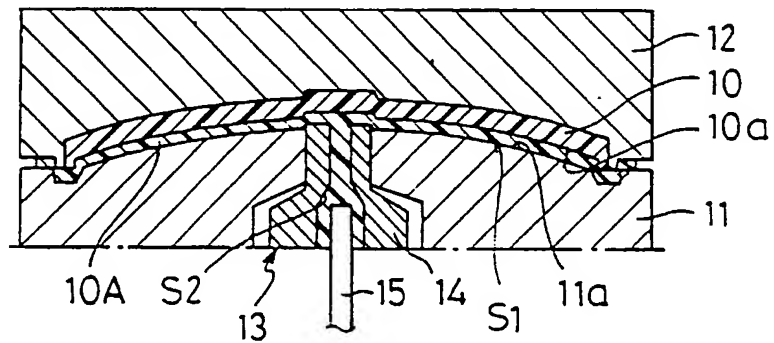


FIG. 14

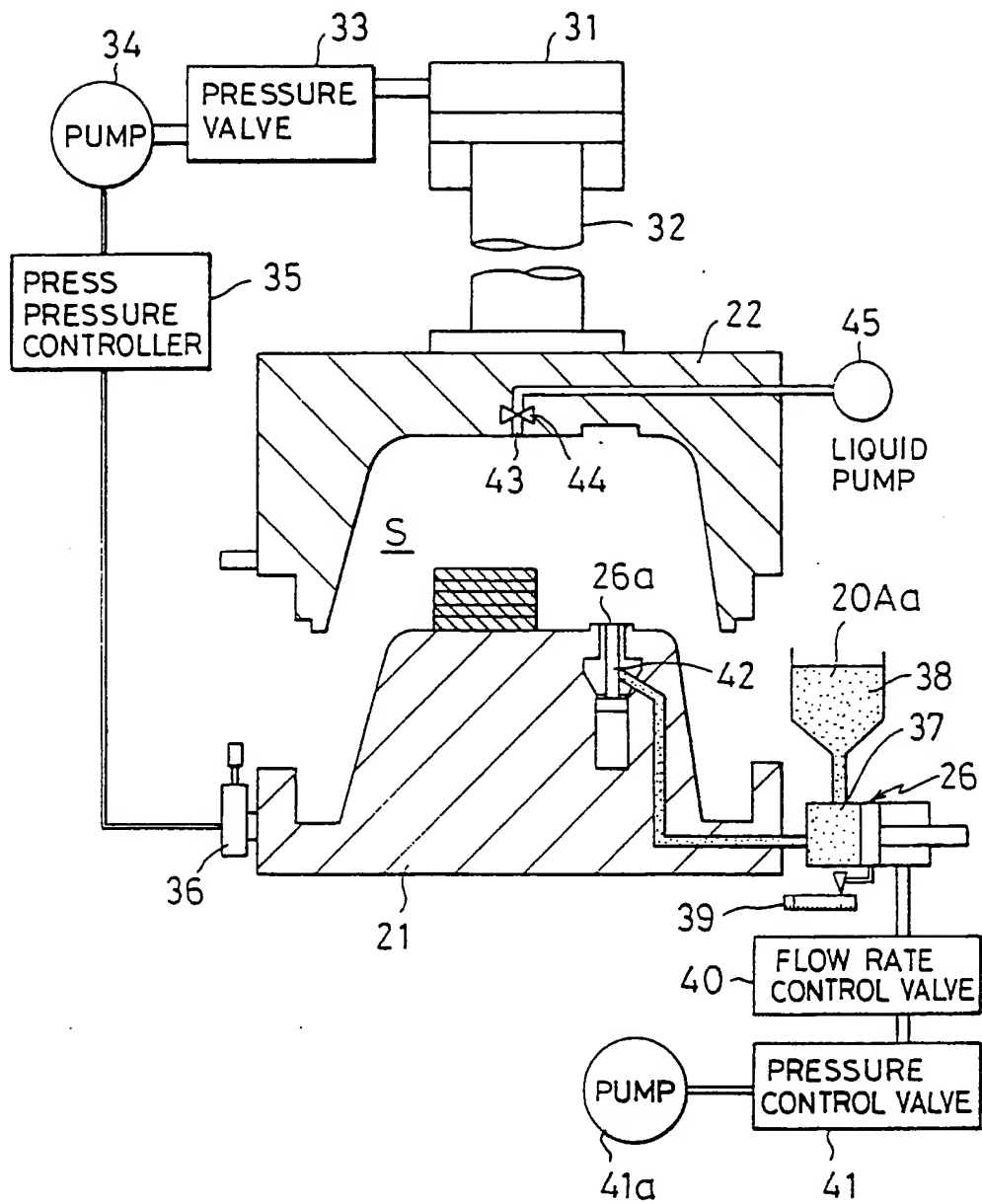


FIG. 15

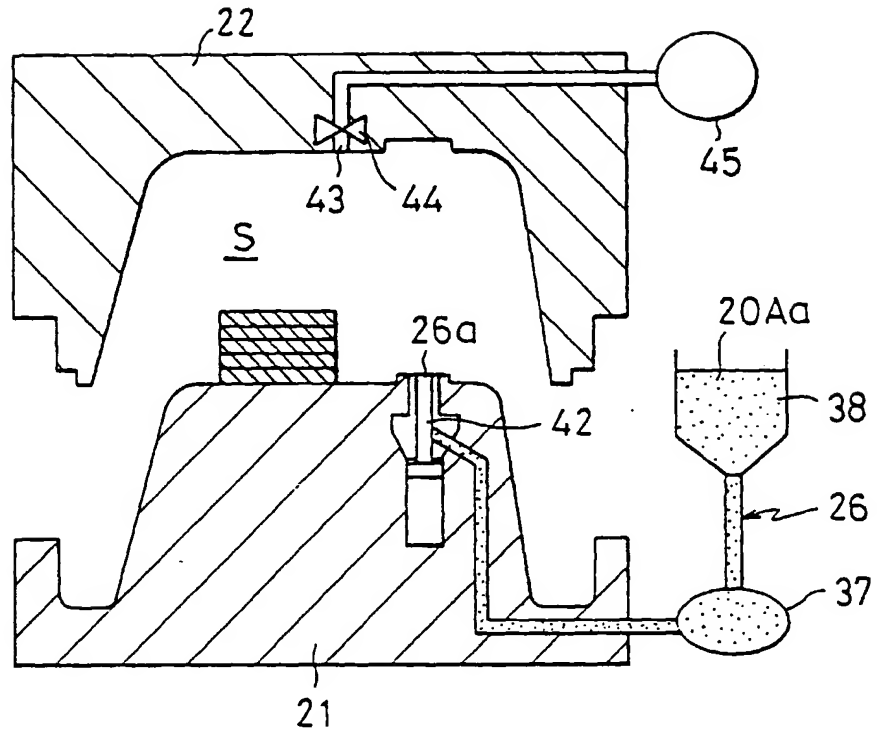


FIG. 16

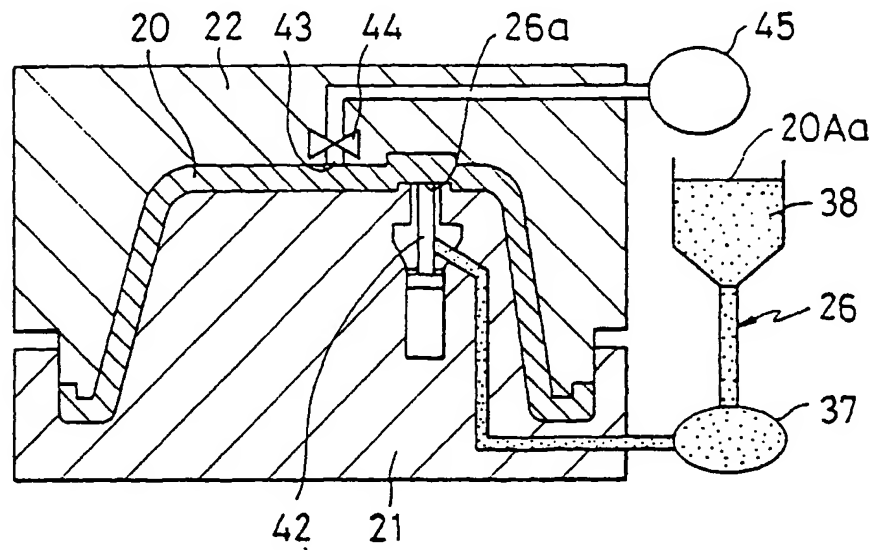


FIG. 17

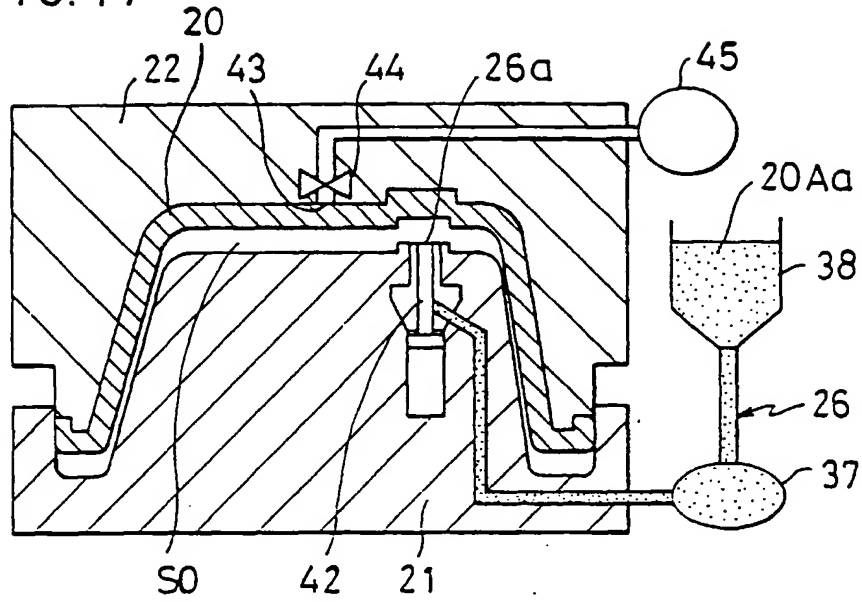


FIG. 18

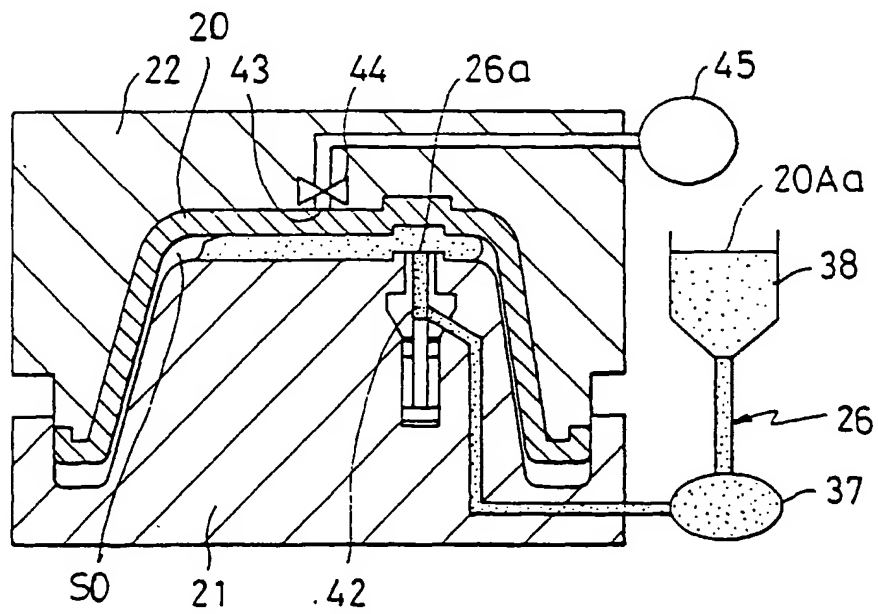


FIG. 19

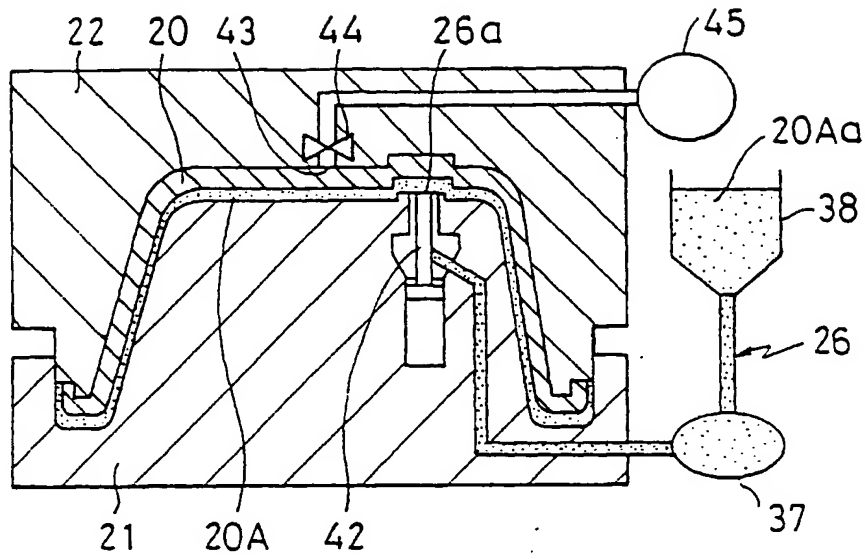


FIG. 20

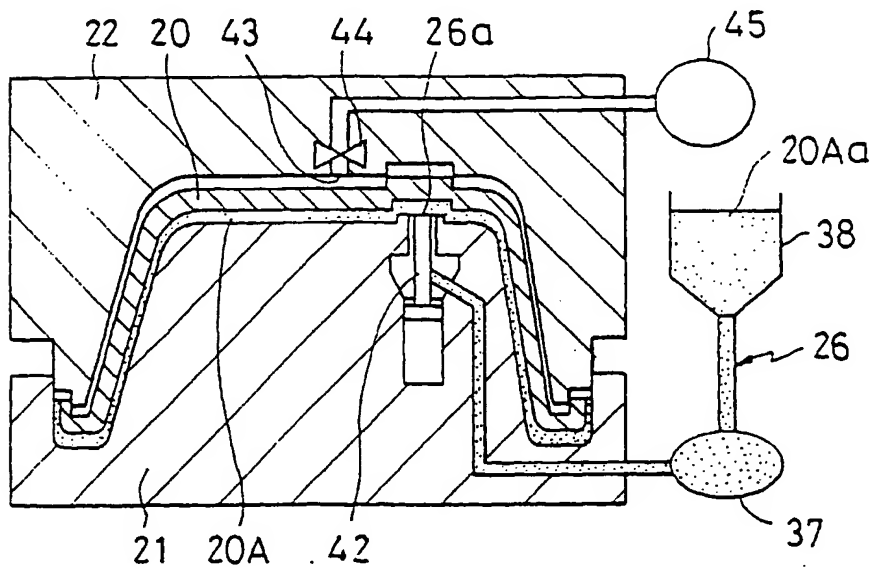


FIG. 21

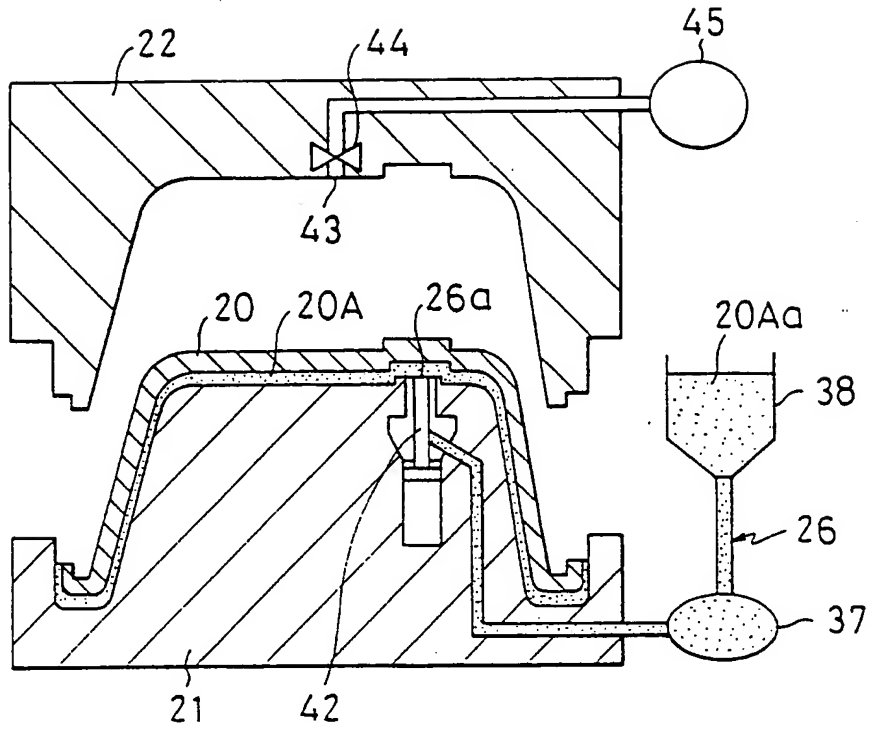


FIG. 22

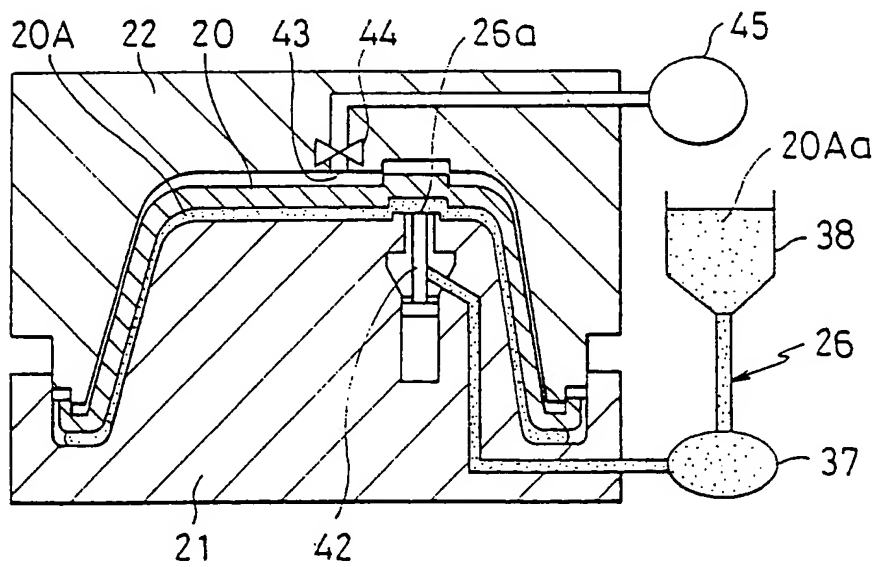


FIG. 23

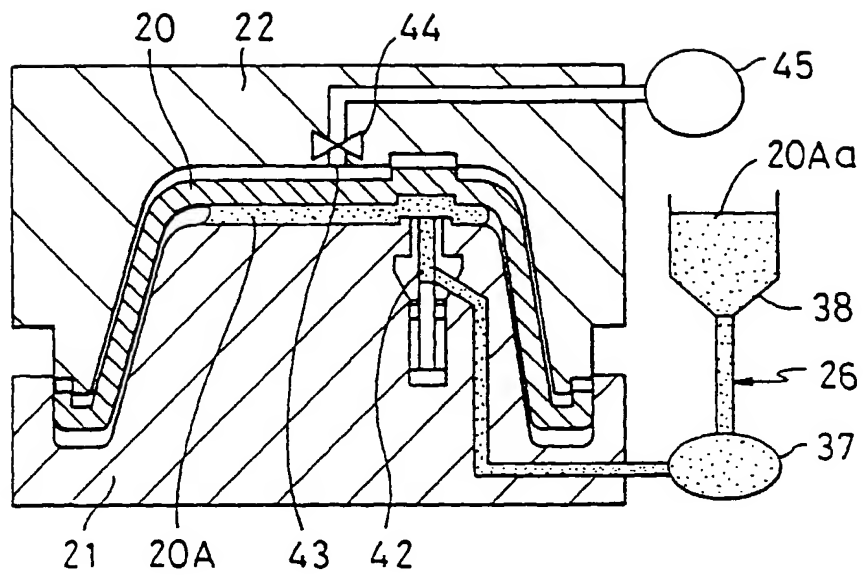


FIG. 24

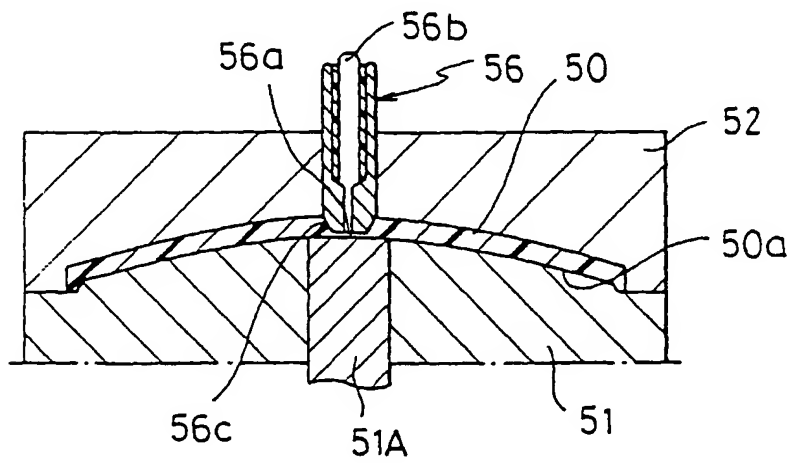


FIG. 25

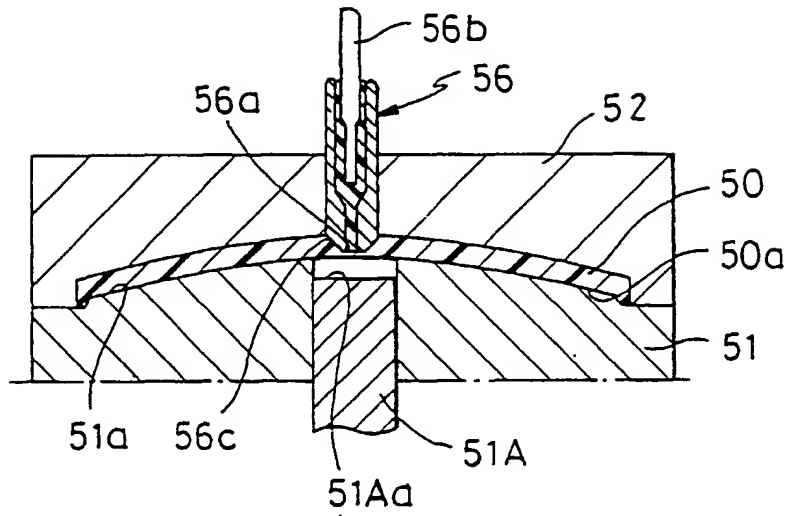


FIG. 26

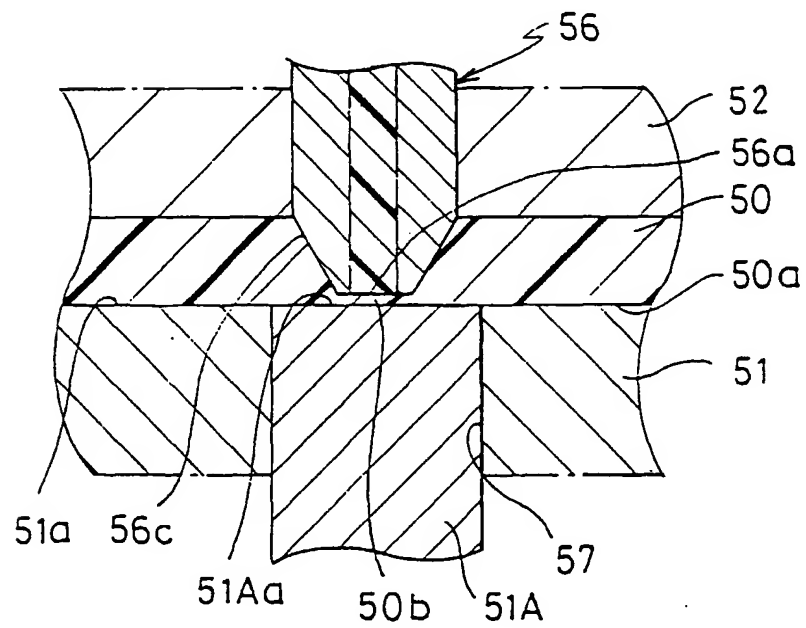


FIG. 27

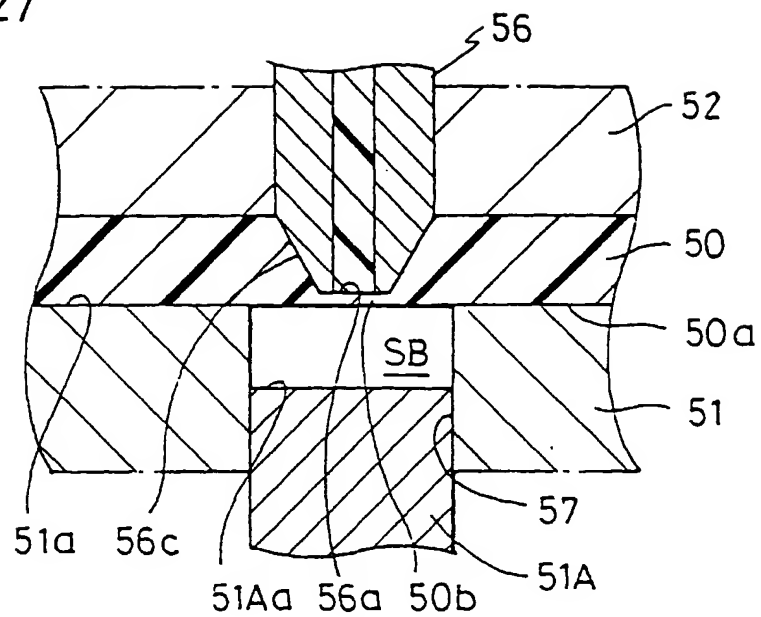


FIG. 28

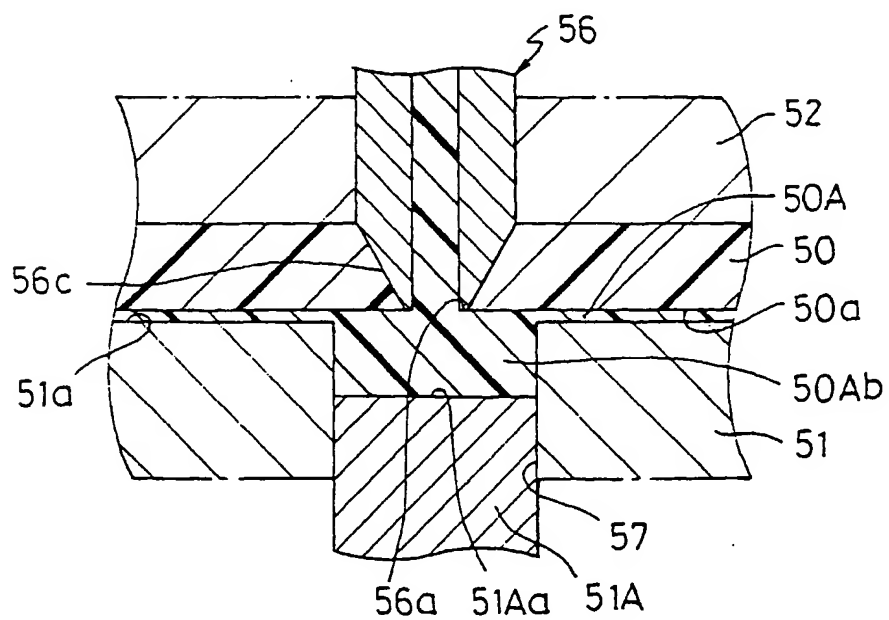


FIG. 29

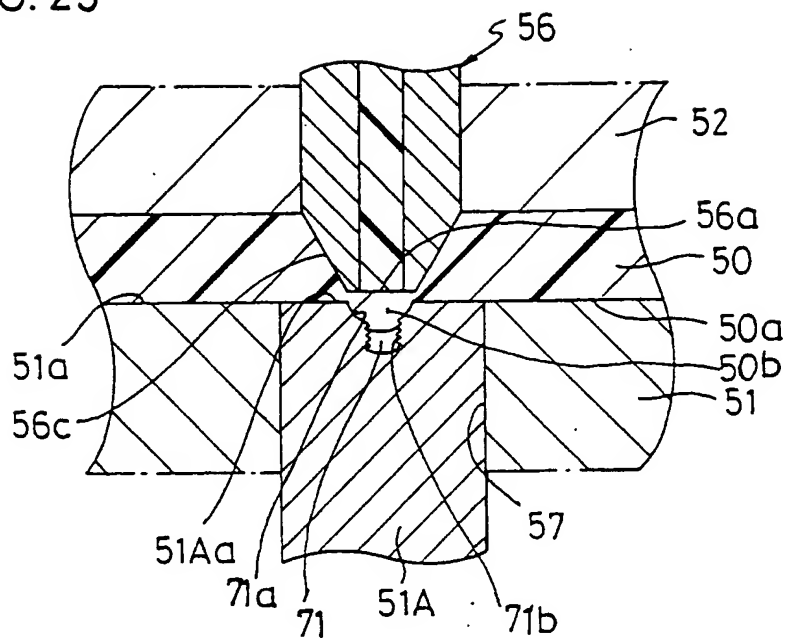


FIG. 30

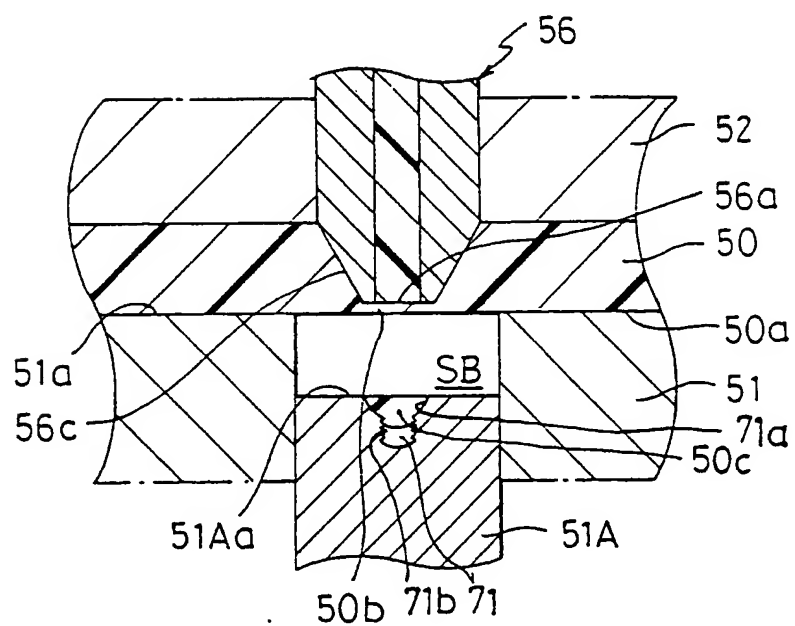


FIG. 31

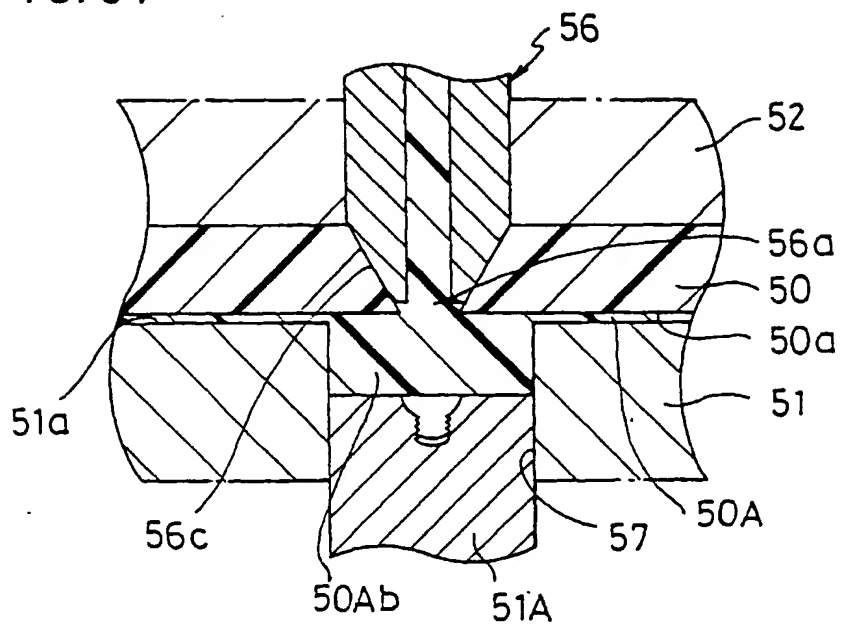


FIG. 32

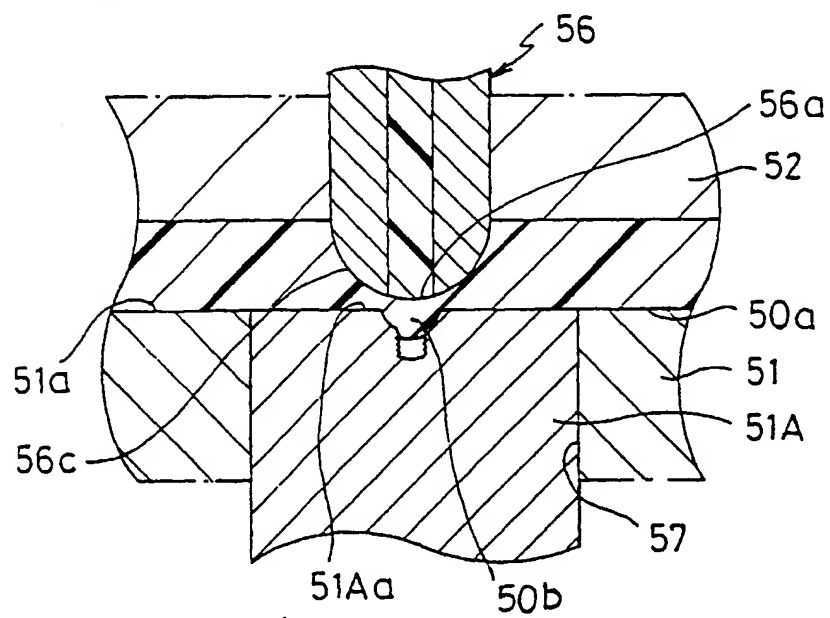


FIG. 33

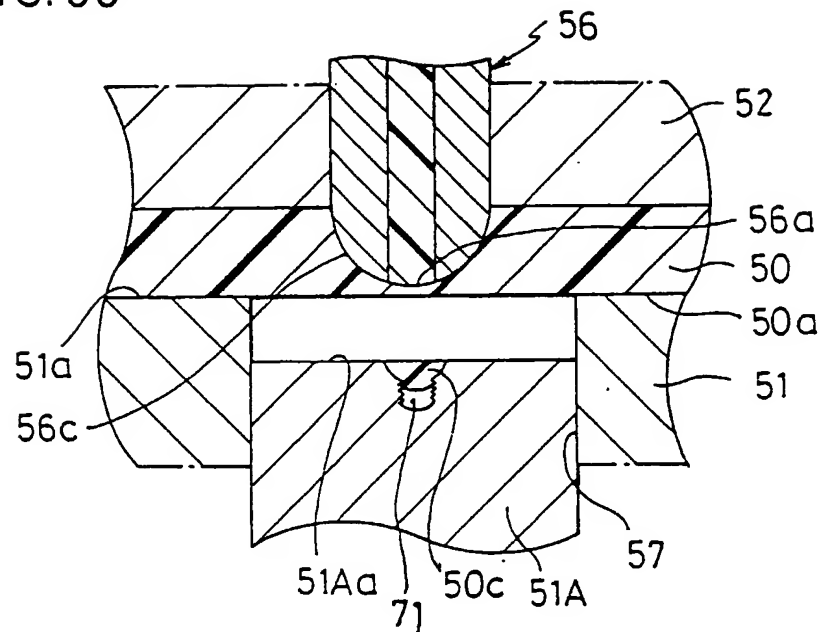


FIG. 34

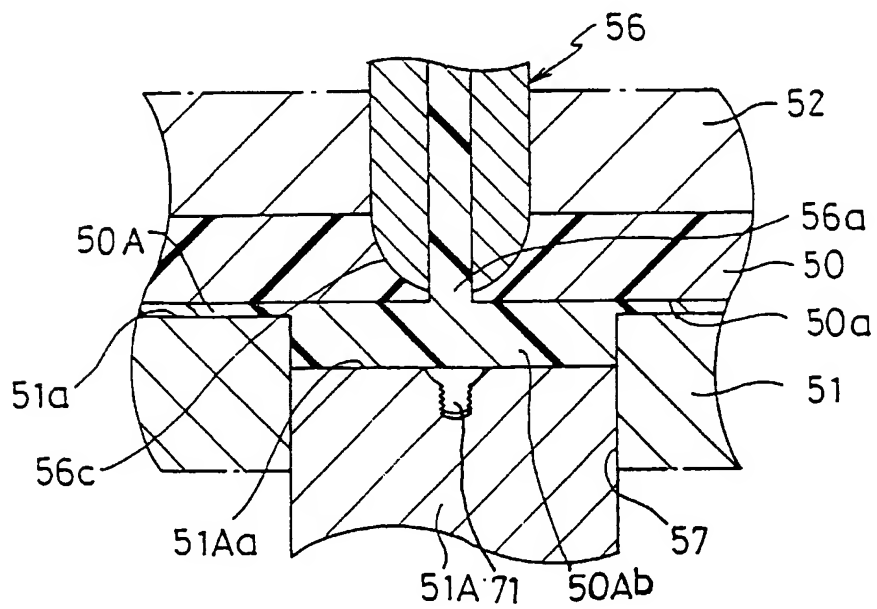


FIG. 35

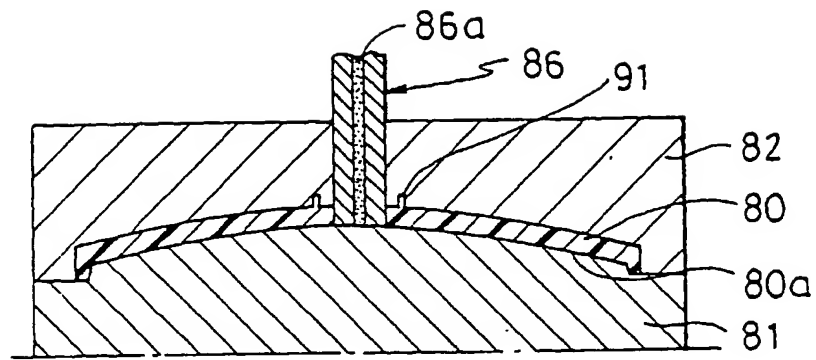


FIG. 36

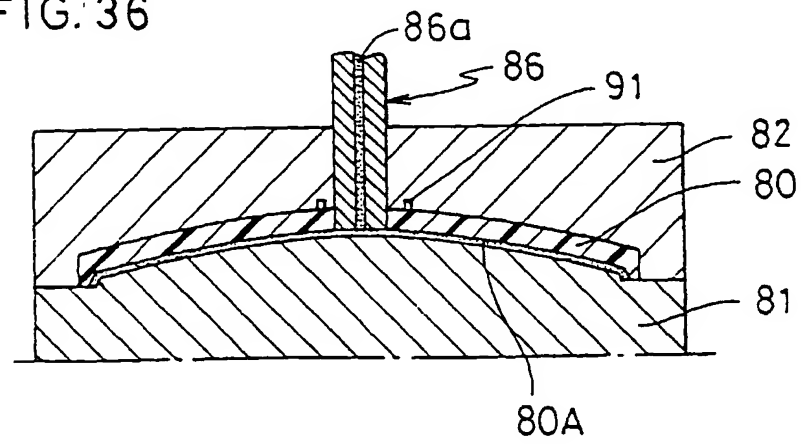


FIG. 37

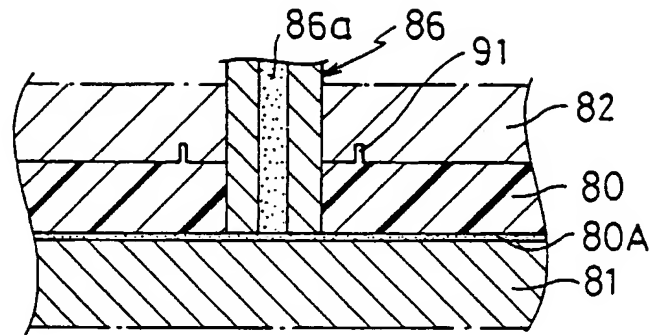


FIG. 38

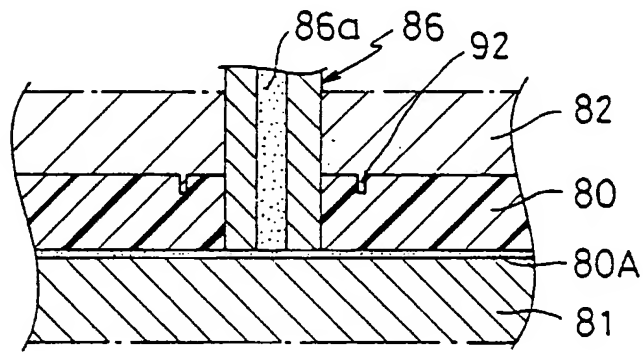


FIG. 39

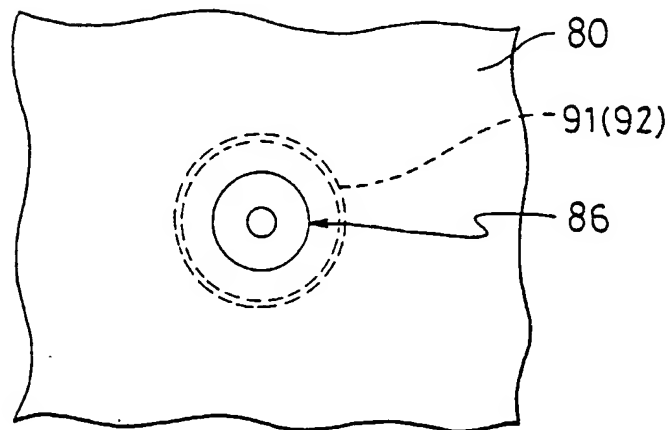


FIG. 40

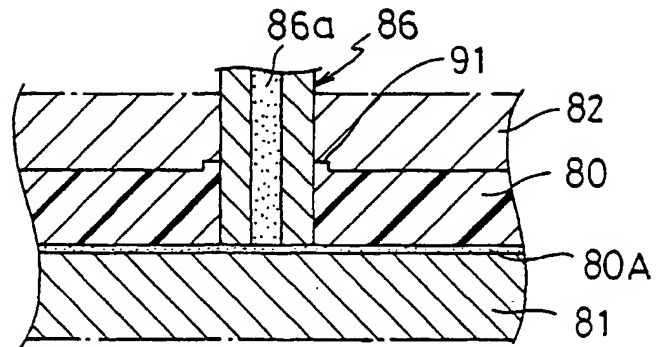


FIG. 41

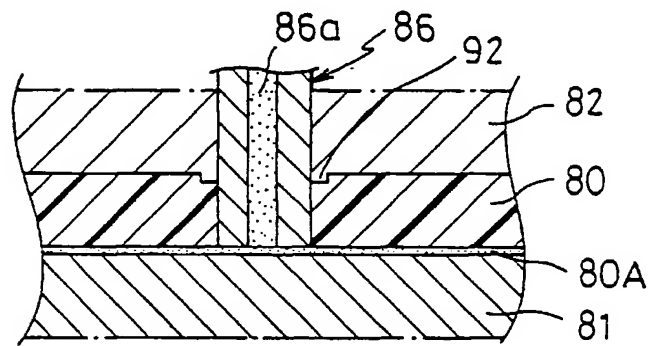


FIG. 42

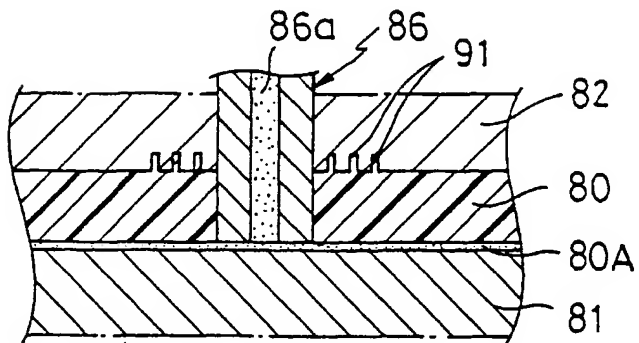


FIG. 43

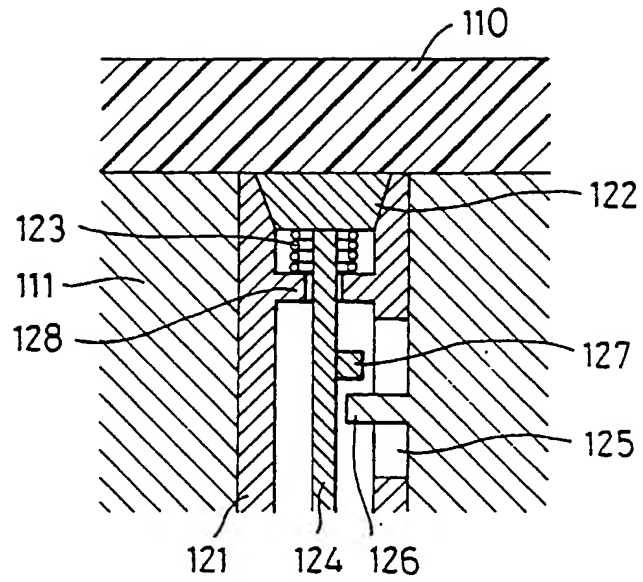


FIG. 44

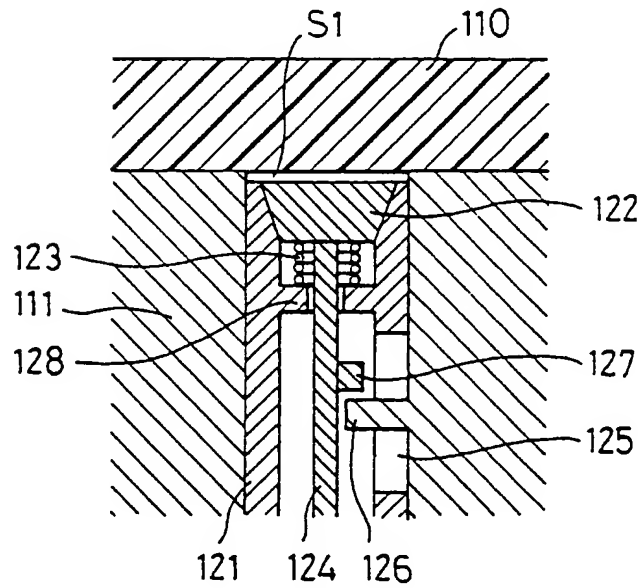


FIG. 45

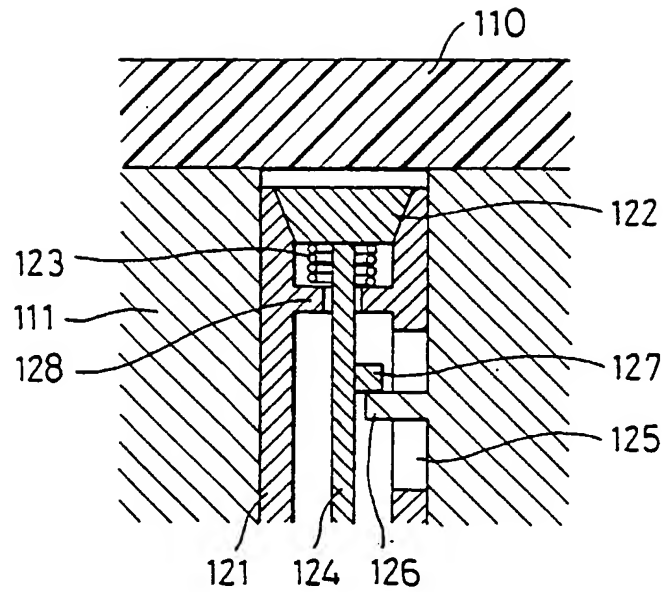


FIG. 46

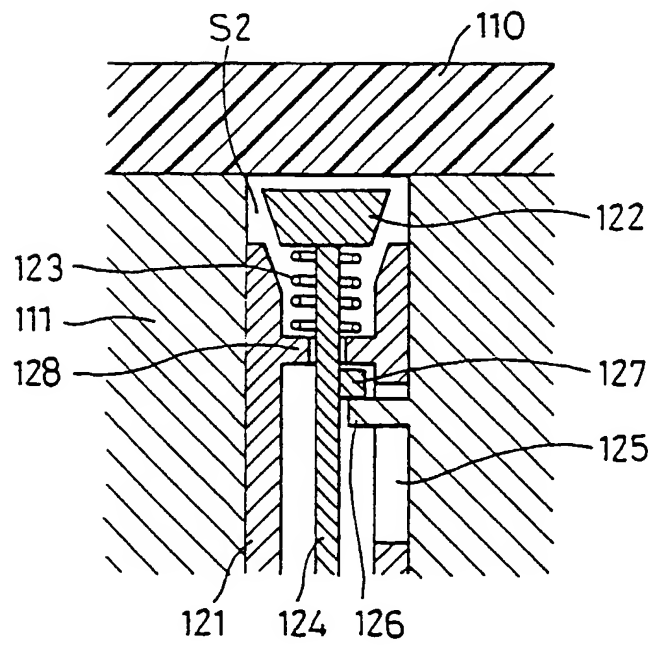


FIG. 47

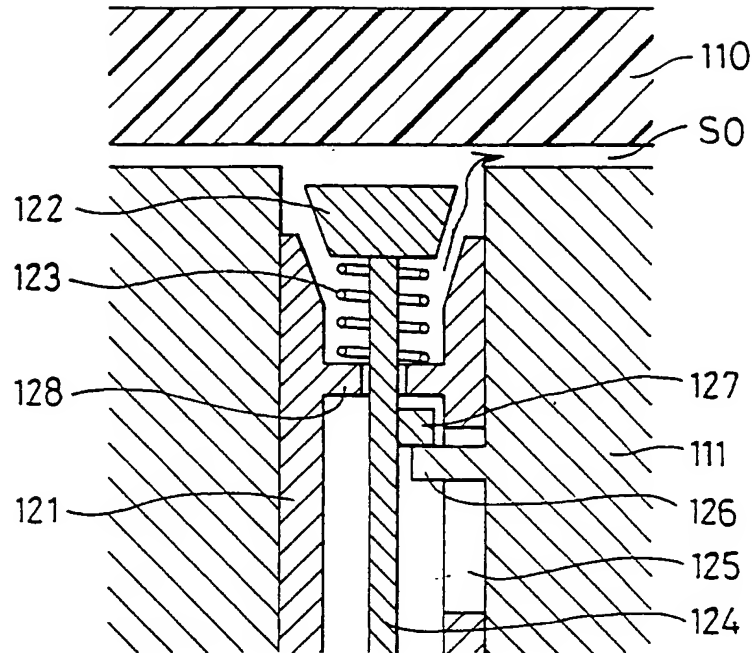


FIG. 48

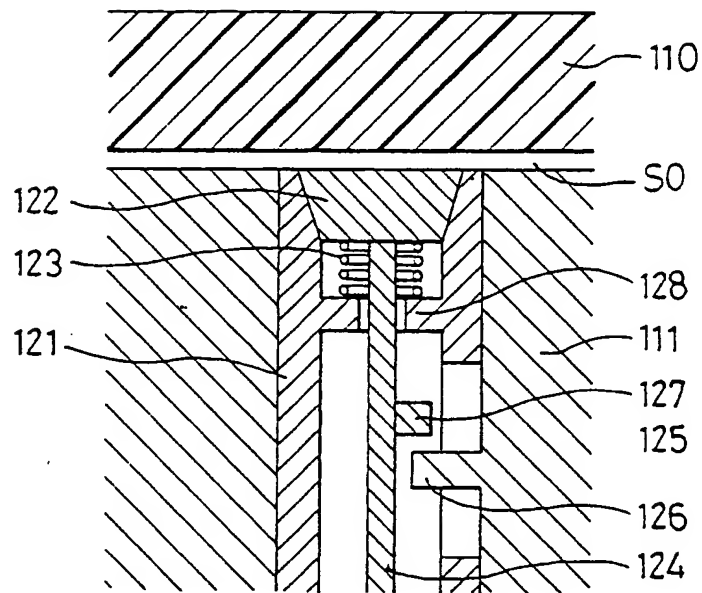


FIG. 49

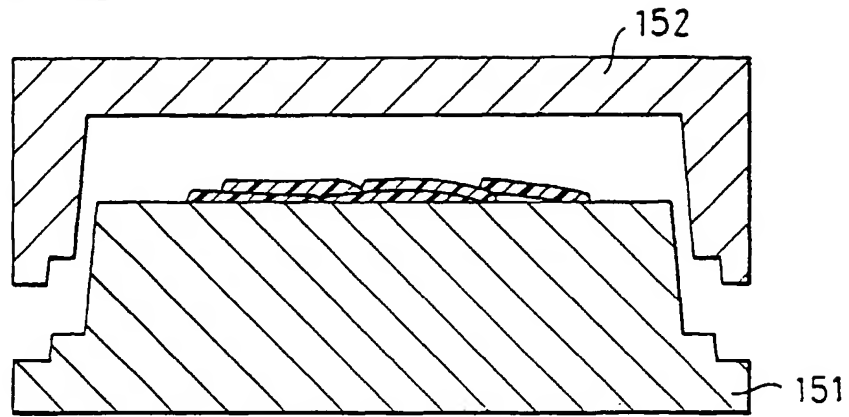


FIG. 50

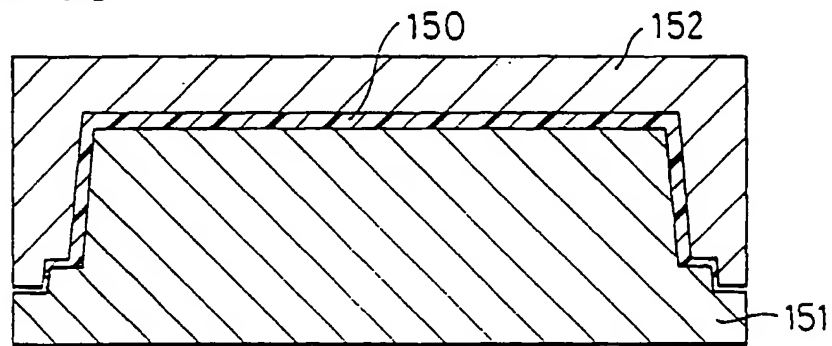


FIG. 51

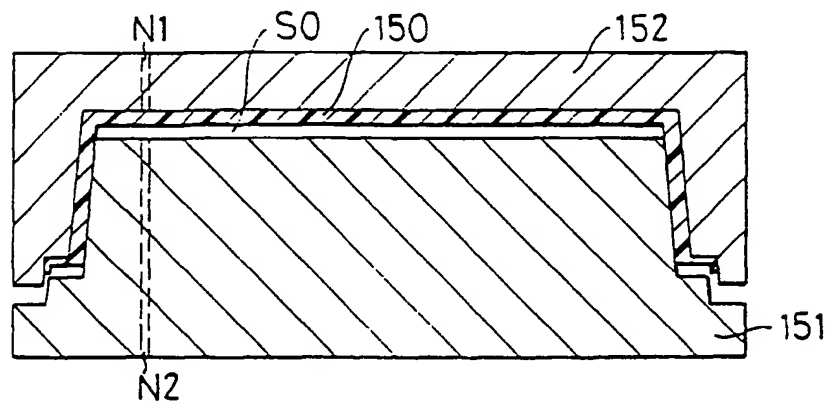


FIG. 52

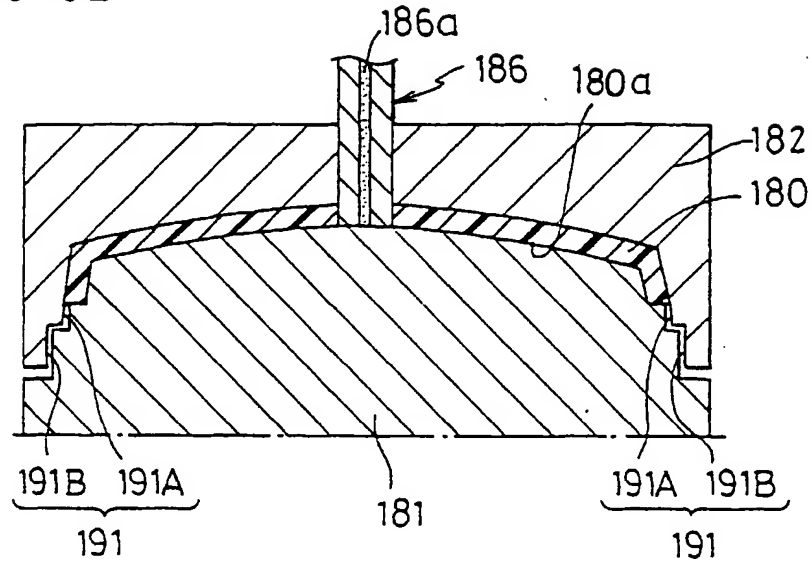


FIG. 53

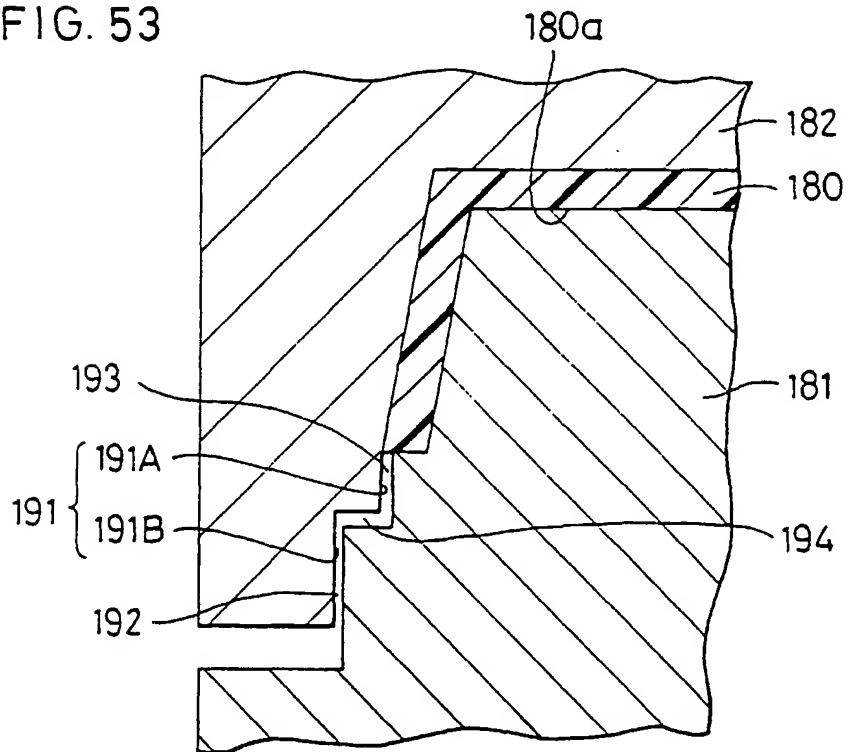


FIG. 54

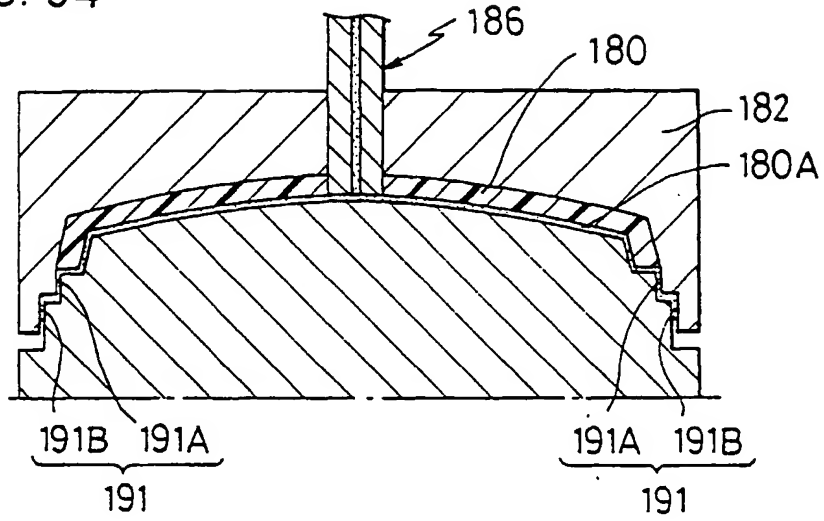


FIG. 55

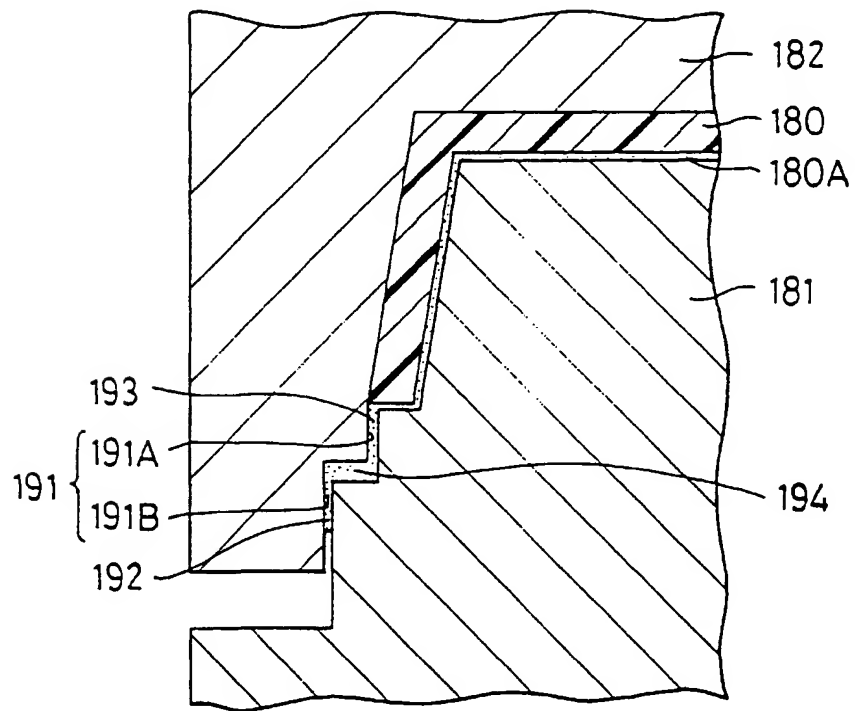


FIG. 56

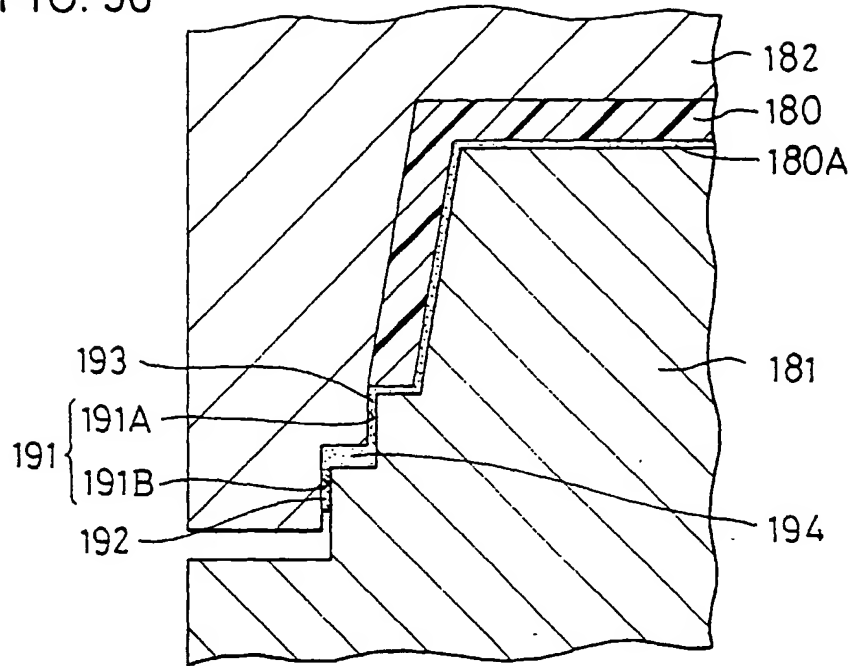


FIG. 57

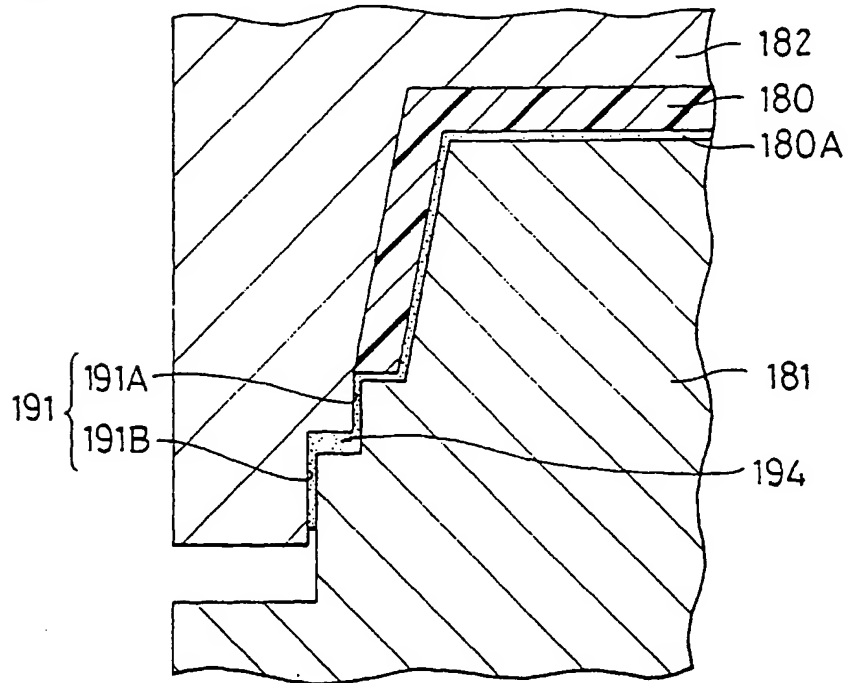


FIG. 58

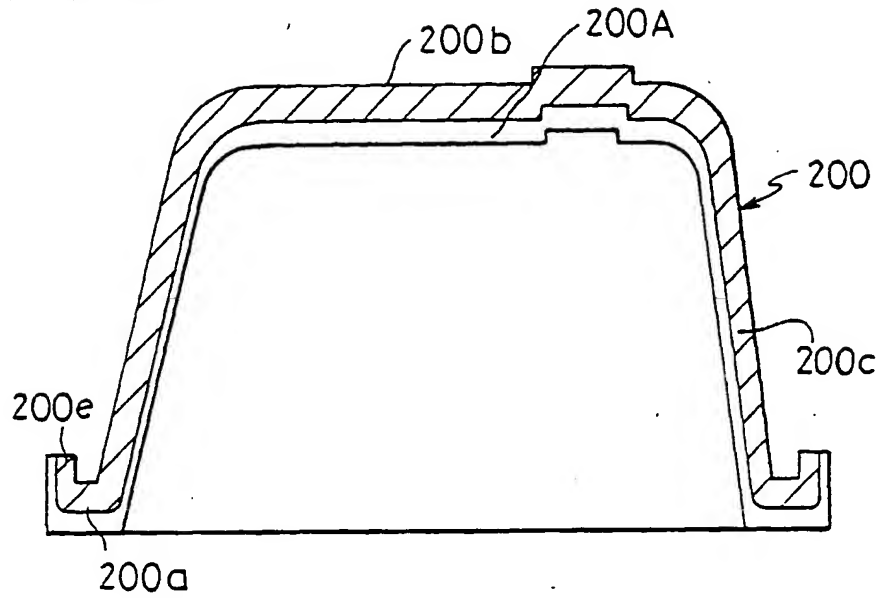


FIG. 59

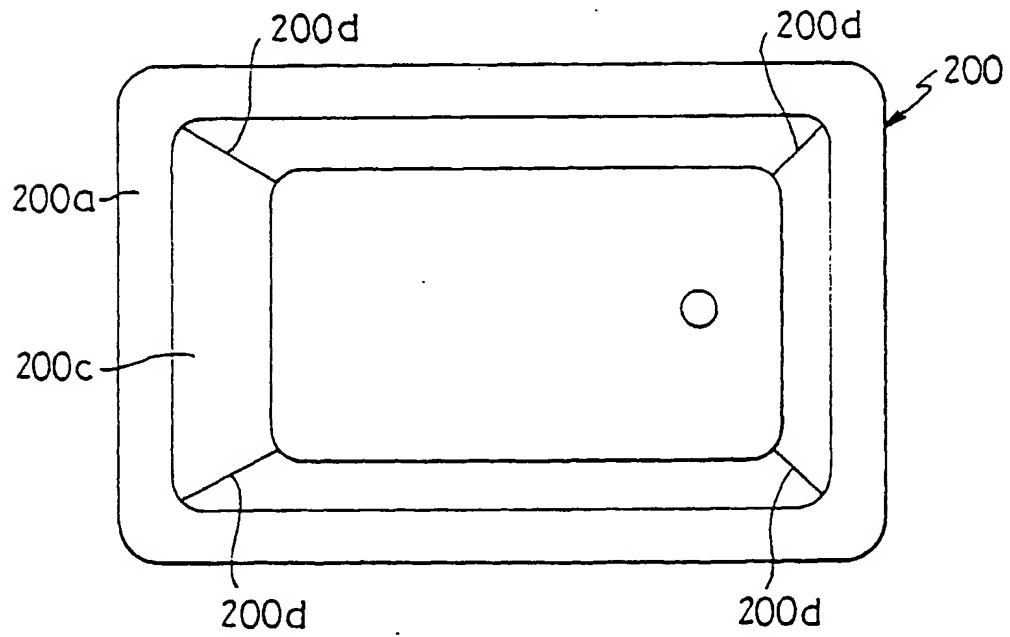


FIG. 60

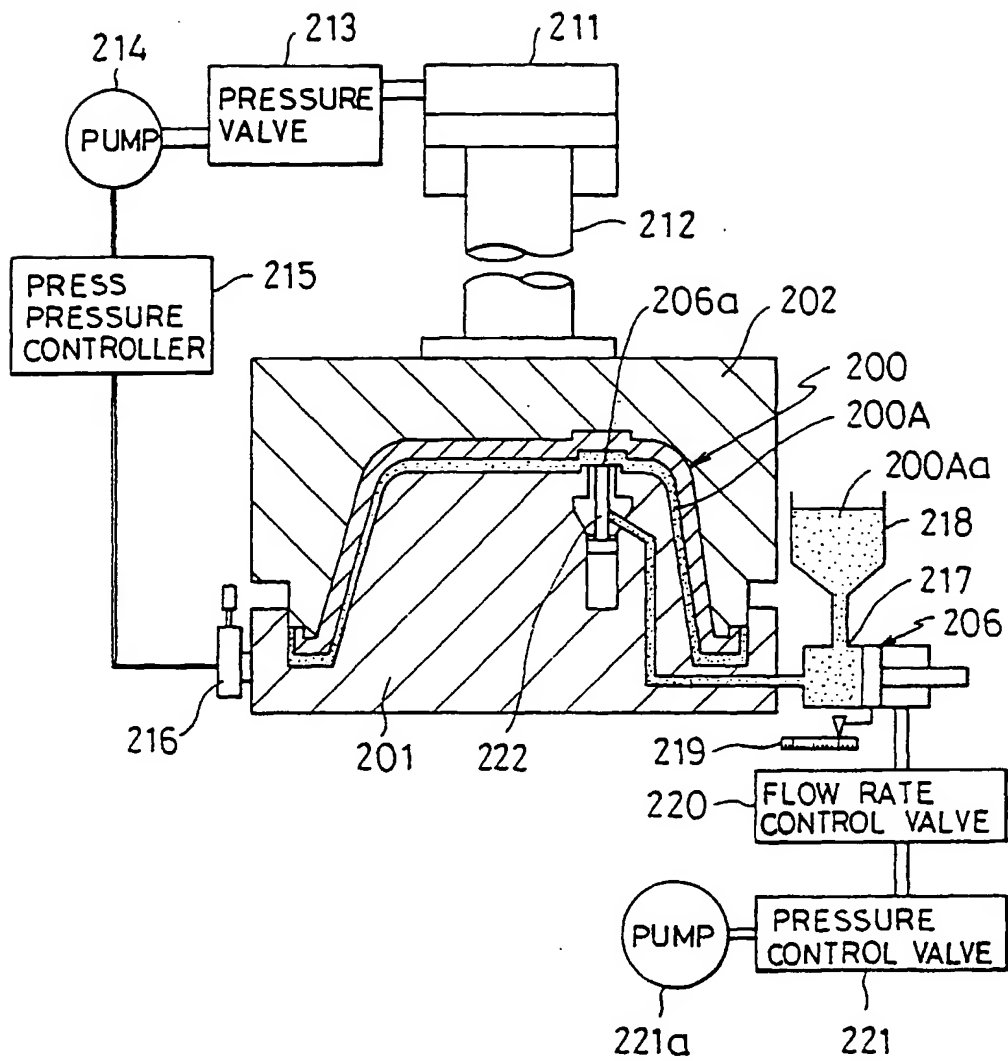


FIG. 61

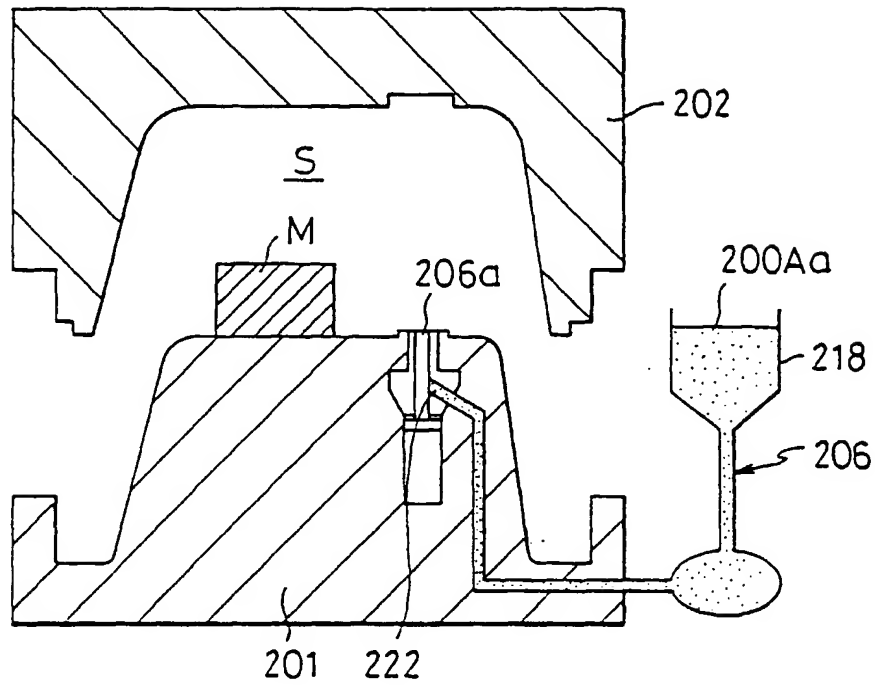


FIG. 62

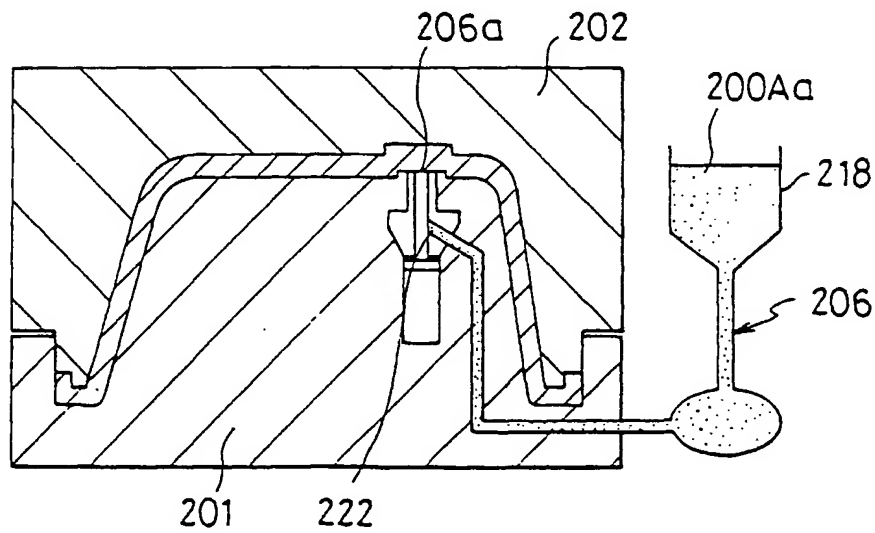


FIG. 63

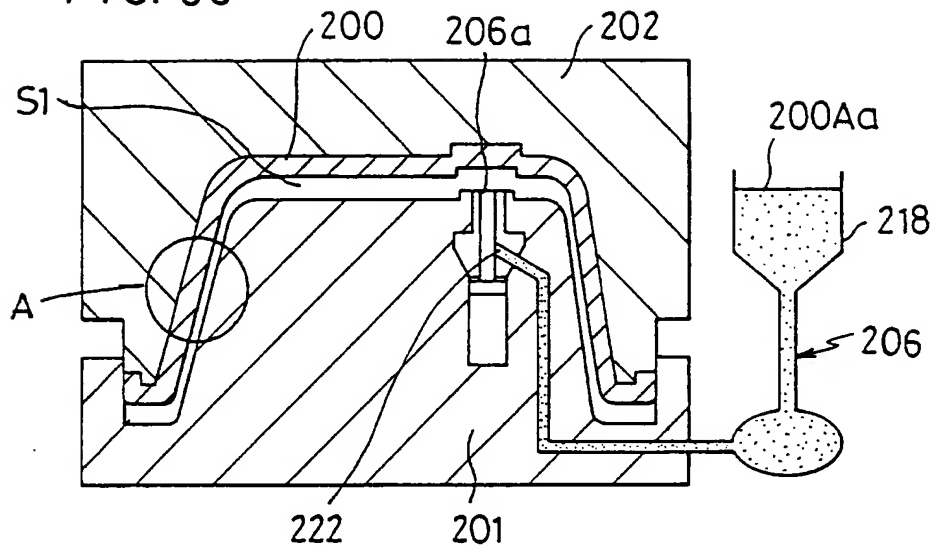


FIG. 64

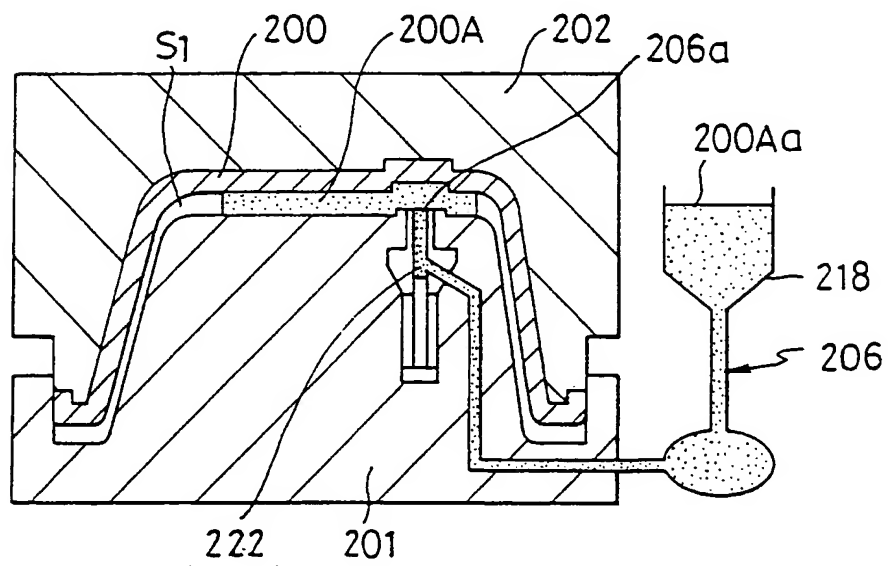


FIG. 65

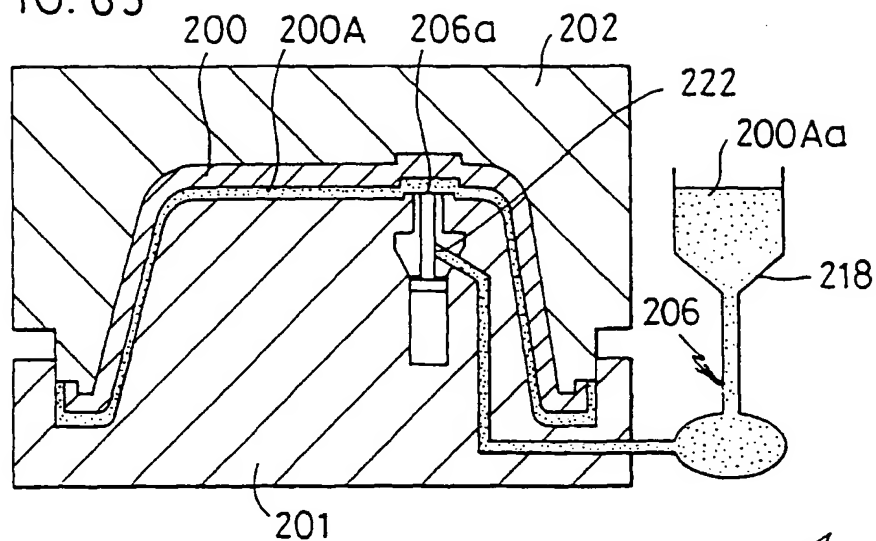


FIG. 67

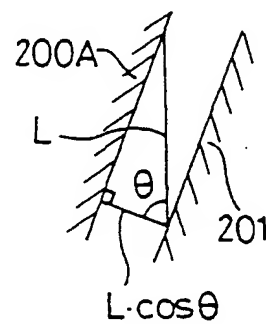


FIG. 66

